

EN 760 : SA AB 2
DIN 32522 : BFB7 6813DC+15B-3-16

DESCRIPTION

- Agglomerated basic flux for submerged arc strip cladding with Soudotape NiCr3 and 625.
- The low silicon content in the weld metal assures a very low hot cracking sensitivity.
- Very low hydrogen content and favourable low moisture pick-up.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 2.3 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 Mesh ASTM)
- Apparent density 0.95
- Consumption 0.6 (kg fused flux / kg strip)
- Redrying 1 to 2 hours at 350 +/- 50°C
- Applicable strip dimensions :

Strip widths (mm)	30	60
Typical deposition rates(kg/h)	8	17

For widths over 60 mm, the Electroslag strip cladding process is recommended.

TYPICAL WELD METAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Base metal 0.18% C - steel.
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 750 A - 26 V - 11 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Nb	Fe	Thickn. (mm)
600	-	NiCr3	0.015	3.2	0.2	20.1	bal.	-	2.6	1.0	-
	1	NiCr3	0.03	3.5	0.3	17.6	bal.	-	2.0	11.6	4.9
	2	NiCr3	0.02	3.6	0.3	19.8	bal.	-	2.2	3.0	4.2
625	-	625	0.02	0.1	0.15	22.0	bal.	9.0	3.6	0.25	-
	1	625	0.04	0.9	0.35	18.5	bal.	7.8	2.7	13.0	4.9
	2	625	0.02	1.0	0.30	20.5	bal.	8.5	3.0	3.0	4.2

PACKING

25 kg (pail) : SAP Stock number :29092.
25 kg (bag) : SAP Stock number :29093.