

DESCRIPTION

- Agglomerated Ni-Mo alloyed flux.
- Suitable for submerged arc strip cladding with Soudotape A.

GENERAL CHARACTERISTICS

- Current DC +
- Basicity index 1.1 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 N° ASTM)
- Apparent density 0.9
- Redrying 1 to 2 hours at 350 +/- 50°C

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

- Base metal 0.18% C - steel
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 1100A – 25V – 13cm/min

Alloy	Layer	Strip Soudotape	C	Mn	Si	Mo	Ni
1.0Ni	1	A	0,120	0,80	0,40	0,35	0,65
0.5Mo	2	A	0,116	0,70	0,50	0,50	0,90

TYPICAL MECHANICAL PROPERTIES (FIRST LAYER ON CARBON STEEL)

Hardness as welded (2nd layer) : 190 HB

PACKING

25 kg (pail)