

EN 760 : SA AB 2
DIN 32522 : BAB7 79DC+6B-6-13

DESCRIPTION

- Agglomerated basic flux for submerged arc strip cladding of pure nickel.
- Allows to deposit pure nickel in 3 layers in combination with Soudotape NiTi .

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1.3 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 Mesh ASTM)
- Apparent density 1.3
- Consumption 0.65 (kg fused flux / kg strip)
- Redrying 1 to 2 hours at 350 +/- 50°C.
- Applicable strip dimensions :

Strip widths (mm)	30
Typical deposition rates(kg/h)	7

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

- Base metal 0.18% C - steel.
- Strip dimensions 30 x 0.5 mm
- Cladding parameters 400 A - 27 V -13 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Ni	Ti	Fe	Thickn. (mm)
200	-	NiTi	0.04	0.35	0.25	bal.	3.2	0.1	-
	1	NiTi	-	-	-	-	-	-	-
	2	NiTi	0.03	1.7	0.6	bal.	1.6	11.0	3.8
	3	NiTi	0.03	1.8	0.7	bal.	2.0	3.0	3.8

PACKING

25 kg (pail) : SAP Stock number : 29099.