

EN 760 : SA AB 3
DIN 32522 : BAB1 79DC+13B-3-16

DESCRIPTION

- Agglomerated flux for submerged arc strip cladding of continuous casting rollers.
- In combination with Soudotape A, Record RT 146 flux deposits a mild steel alloy.
- Excellent technology and easy slag removal even at high temperatures.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 0.8 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 -1.4 mm (14x40 Mesh ASTM)
- Apparent density 1.15
- Consumption 0.8 (kg fused flux / kg strip)
- Redrying 1 to 2 hours at 350 +/- 50°C
- Applicable strip dimensions :

Strip widths (mm)	30	60	90
Typical deposition rates (kg/h)	10	18	25

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

- Base metal 0.18% C - steel
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 1250 A- 28V -15cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Thickness (mm)	Hardness
Mild steel	-	A	0.03	0.2	0.02		
	1	A					
	2	A					
	3	A	0.045	0.95	0.5	4.4	150 HB
	4	A	0.04	0.9	0.5	4.4	150 HB

PACKING

25 kg (bag) : SAP stock number : 29175.