

EN 760 : SA CS3NiMo  
DIN 32522 : BCS4 851NiMoDC+13B-3-16

## DESCRIPTION

- Agglomerated flux for submerged arc strip hardfacing of continuous casting rolls.
- In combination with Soudotape 430 or 430L strip, Record RT 152 flux deposits a 13 Cr -4 Ni -1 Mo alloy.
- Excellent technology and easy slag removal even at high temperatures.

## GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1 ( according to Bonizewski; calculated in mole % )
- Grain size 0.4 -1.4 mm ( 14 x 40 N° ASTM )
- Apparent density 1.05
- 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)	6.5	13	20

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

- Base metal 0.18% C - steel.
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 650 A - 27 V -13 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Thickness (mm)	Hardness
13 Cr 4 Ni 1 Mo	-	430	0.06	0.45	0.35	16.3	0.15	-	-	-
	1	430	-	-	-	-	-	-	-	-
	2	430	0.06	0.45	1	13.2	4	0.8	3.5	370 HB
13 Cr 4 Ni 1 Mo	3	430	0.06	0.45	1	13.7	4.2	0.85	3.5	360 HB
	-	430L	0.02	0.4	0.4	16.8	0.1	-	-	-
	1	430L	-	-	-	-	-	-	-	-
13 Cr 4 Ni	2	430L	0.02	0.4	0.9	13.7	3.8	0.8	3.5	345 HB
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1 Mo	3	430L	0.02	0.4	0.9	14	4	0.9	3.5	330 HB

## PACKING

25 kg ( bag ) : SAP Stock number : 29185 .  
25 kg ( pail ) : SAP Stock number : 29184 .