

DESCRIPTION

- Agglomerated flux for submerged arc strip hardfacing of continuous casting rolls.
- Especially developed to be used with Soudotape 430 or Soudotape 420.
- Excellent technology and easy slag removal, even at high temperatures.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1.1 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 Mesh ASTM)
- Apparent density 1
- 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)	8	15	22

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

- Base metal 0.18 % C –Steel.
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 900 A – 26 V – 12 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Thickn. (mm)	Hardness or FN
430	-	430	0.06	0.45	0.35	16.3	-	-
	1	430	-	-	-	-	-	-
	2	430	0.075	0.35	0.8	13.4	3.5	260 HB
	3	430	0.07	0.35	0.8	15	3.9	240 HB
420	-	420	0.33	0.3	0.35	13.2	-	-
	1	420	-	-	-	-	-	-
	2	420	0.23	0.3	0.9	11.9	3.9	50 HRc
	3	420	0.23	0.23	1	12.9	3.9	52 HRc

PACKING

25 kg (bag) : SAP Stock number : 25208.
25 kg (pail) : SAP Stock number : 29186.