

EN 760 :
DIN 32522 :

SA CS3 CCrNiMoNbV
BCS4 954DC+13B-3-16

DESCRIPTION

- C-Cr-Ni-Mo-Nb-V agglomerated basic flux for submerged arc strip cladding.
- Especially developed for hard surfacing of rolls in combination with Soudotape 410L and Soudotape S258.
- Excellent technology and easy slag removal, even at high temperatures.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1.2 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 Mesh ASTM)
- Apparent density 1.1
- Consumption 0.8 (kg fused flux / kg strip)
- Redrying 1 to 2hours 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 – 13 cm/min.

| Alloy | Layer | Strip Soudotape | C | Mn | Si | Cr | Ni | Mo | Nb | V | W | Thickn. (mm) | Hardness HRc |
|----------|-------|-----------------|------|------|------|------|-----|------|-----|------|------|--------------|--------------|
| 410 | - | 410L | 0.03 | 0.3 | 0.35 | 12.3 | - | - | - | - | - | - | - |
| NiMo VNb | 1 | 410L | - | - | - | - | - | - | - | - | - | - | - |
| | 2 | 410L | 0.14 | 0.3 | 0.8 | 11.8 | 2.6 | 1.4 | 0.3 | 0.27 | - | 3.8 | 42 |
| | 3 | 410L | 0.14 | 0.3 | 0.9 | 12 | 2.5 | 1.3 | 0.3 | 0.27 | - | 3.5 | 44 |
| 410 | - | S258 | 0.29 | 1.65 | 0.45 | 6.3 | - | 1.40 | - | - | 1.65 | - | - |
| NiMo VNb | 1 | S258 | - | - | - | - | - | - | - | - | - | - | - |
| | 2 | S258 | 0.25 | 0.9 | 0.9 | 6.4 | 1.9 | 2.2 | 0.2 | 0.2 | 1.5 | 4.3 | 46/52* |
| | 3 | S258 | 0.25 | 0.9 | 0.9 | 6.5 | 1.8 | 2.1 | 0.3 | 0.2 | 1.5 | 4.3 | 50 |

* Treated during 6 hours at 525 ° C.

PACKING

25 kg (bag) : SAP Stock number : 29187