

DESCRIPTION

- Agglomerated flux for submerged arc strip hardfacing of continuous casting rolls.
- Can be used with various types of strips, for example Soudotape 410L ,Soudotape 420,Soudotape 430 and Soudotape S258.

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 0.6 (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) | 7 | 15 | 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 750 A – 28 V – 12 cm/min.

| Alloy | Layer | Strip Soudotape | C | Mn | Si | Cr | Ni | Mo | Nb | W | Thickn. (mm) | Hardness or FN |
|-------|-------|-----------------|------|------|------|------|----|----|----|---|--------------|----------------|
| 410L | - | 410L | 0.03 | 0.3 | 0.35 | 12.3 | - | - | - | - | - | - |
| | 1 | 410L | - | - | - | - | - | - | - | - | - | - |
| | 2 | 410L | 0.04 | - | - | 10.9 | - | - | - | - | 3.8 | 290 HB |
| | 3 | 410L | 0.03 | 0.1 | 0.85 | 11.2 | - | - | - | - | 3.8 | 260 HB |
| 420 | - | 420 | 0.33 | 0.3 | 0.35 | 13.2 | - | - | - | - | - | - |
| | 1 | 420 | - | - | - | - | - | - | - | - | - | - |
| | 2 | 420 | 0.2 | - | - | 11.6 | - | - | - | - | 3.6 | 45 HRc |
| | 3 | 420 | 0.2 | 0.15 | 0.85 | 12.2 | - | - | - | - | 3.5 | 48 HRc |
| 430 | - | 430 | 0.06 | 0.45 | 0.35 | 16.3 | - | - | - | - | - | - |
| | 1 | 430 | - | - | - | - | - | - | - | - | - | - |
| | 2 | 430 | 0.07 | - | - | 14.4 | - | - | - | - | 3.5 | 240 HB |
| | 3 | 430 | 0.06 | 0.2 | 0.85 | 15 | - | - | - | - | 3.2 | 230 HB |

Flux for cladding

| | | | | | | | | | | | | |
|-----|---|------|----------|----------|----------|-----|---|-----|---|----------|-----|--------|
| 258 | - | S258 | 0.2 9 | 1.6 5 | 0.4 5 | 6.3 | - | 1.4 | - | 1.6 5 | - | - |
| | 1 | S258 | - | - | - | - | - | - | - | - | - | - |
| | 2 | S258 | 0.1 8 | - | - | 6 | - | - | - | - | 3.5 | 45 HRc |
| | 3 | S258 | 0.1 8 | - | - | 6.1 | - | 1.4 | - | 1.6 | 3.1 | 48 HRc |

PACKING

25 kg (pail) : SAP Stock number : 29188.

25 kg (bag) : SAP Stock number : 29189.