

EN 760 :
DIN 32522 :

SA CS 3CrNiMo
BCS5 959DC+13B-3-16

DESCRIPTION

- Alloyed agglomerated flux for submerged arc strip hardsurfacing of rolls.
- Allows to deposit a 13 Cr – 4 Ni – 1 Mo – alloy in only one layer in combination with Soudotape 430.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1.7 (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)	6.5	13	20

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

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

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Thickn. (mm)	Hardness HRC
13Cr	-	430	0.06	0.45	0.35	16.3	0.10	-	-	-
4 Ni	1	430	0.08	0.50	1.0	14.0	3.80	0.9	3	41

PACKING

25 kg (pail) : SAP Stock number : 29191.
25 kg (bag) : SAP Stock number : 29192.