

DESCRIPTION

- Agglomerated flux for submerged arc strip hardfacing of continuous casting rolls.
- Especially developed to be used on small continuous casting rolls ($\varnothing = 150\text{mm}$) in combination with Soudotape 430L 30x0.5mm

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 0.96 (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
Typical deposition rates (kg/h)	7

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

- Base metal 0.2%C - steel
- Strip dimensions 30 x 0.5 mm
- Cladding parameters 300A – 26V – 16cm/min – 250°C

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Hardness
12Cr6Ni2Mo	-	430L	0.010	0.44	0.31	16.0	-	-	-
	1	430L	0.075	0.39	0.61	9.5	3.9	2.0	-
	2	430L	0.027	0.26	0.72	12.1	4.7	2.5	-
	3	430L	0.017	0.22	0.79	12.9	5.2	2.6	35HRc

PACKING

25 kg (pail) : SAP Stock number : 61506