

DESCRIPTION

- Cr – Mo alloyed agglomerated flux designed for SAW strip cladding for continuous casting rollers.
- Hardness deposit of about +/- 300 HB in combination with a Soudotape A.

GENERAL CHARACTERISTICS

- Current DC +.
- Basicity index 0.63 (according to Bonizewski; calculated in mole %).
- Grain size 0.25 - 1 mm (18 x 60 N° ASTM).
- Apparent density 1,2
- Consumption 1 (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)	10	18	25

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

- Base metal 0.2% C - steel
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 1275 A – 24 V – 15 cm/min

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Mo	Thickn (mm)	Hardness
3 Cr – 0.5Mo	-	A	0.03	0.2	0.02	-	-	-	-
	3	-	0.08	0.7	0.7	3	0.4	4.4	290 HB

PACKING

25 kg (bag) : SAP stock number : 41972