

EN 760 : SA AB 3CCrMo  
 DIN 32522 : BAB3 74CCrMoDC+13B-3-16

## DESCRIPTION

- C - Cr - Mo alloyed agglomerated basic flux for SAW strip hardfacing of rolls.
- In combination with Soudotape A or Soudotape B, Record RT 400 D flux deposits a 0.15C- 6 Cr - 1 Mo alloy.

## GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1.6 ( according to Bonizewski; calculated in mole % )
- Grain size 0.4 – 1.4 mm (14 x 40 Mesh ASTM )
- Apparent density 1
- Consumption 0.9 ( 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	20	30

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

- Base metal 0.18 % C - steel.
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 1200 A – 28 V -21 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Mo	Thickness (mm)	Hardness HRc
0.15 C 6 Cr 1 Mo	-	A	0.03	0.20	0.02	-	-	-	-
	1	A	-	-	-	-	-	-	-
	2	A	-	-	-	-	-	-	-
	3	A	0.12	0.30	0.40	5.5	0.9	3.1	40
	4	A	0.12	0.30	0.40	6.2	1	3	40
0.15 C 6 Cr 1 Mo	-	B	0.07	0.45	0.04	-	-	-	-
	1	B	-	-	-	-	-	-	-
	2	B	-	-	-	-	-	-	-
	3	B	0.14	0.35	0.40	5.8	0.9	3.1	42
	4	B	0.14	0.30	0.45	6.1	1	3	42

## PACKING

25 kg ( bag ) :SAP Stock number : 29180.