

## DESCRIPTION

- C-Cr-Mo alloyed agglomerated basic flux for submerged arc strip hardfacing.
- In combination with Soudotape A, Record RT 500 deposits a 0.35 C – 6 Cr – 3 Mo in 3 layers to reach a level of hardness of 50 HRC.

## GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1.6 ( according to Bonizewski; calculated in mole % )
- Grain size 0.25 - 1 mm ( 14 x 40 N° 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
Typical deposition rates (kg/h)	8	16

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

- Base metal 0.18 % C - steel.
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 1000 A - 28 V – 15 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Thickn. (mm)	Hardness (HRC)
0.35 C 6 Cr 3 Mo	-	A	0.03	0.21	0.012				
	1	A	0.30	0.50	0.39	4.45	2.22	3.8	47
	2	A	0.32	0.30	0.31	5.64	2.76	3.8	45
	3	A	0.34	0.26	0.33	6.02	2.96	3.8	51

## PACKING

25 kg (pail) : SAP stock number :