

## DESCRIPTION

- C-Ni-Cr-Mo-V alloyed agglomerated basic flux for submerged arc strip hardfacing.
- In combination with Soudotape A, Record RT 500 deposits a 28CrNiMoV85 alloy in 3 layers.

## 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	Mo	V	Hardness (HB)
28CrNiMoV85	-	A	0.03	0.21	0.012	-	-	-	-	-
	1	A	0.24	0.50	0.49	1.09	1.57	0.42	0.09	283
	2	A	0.26	0.32	0.49	1.36	1.96	0.53	0.11	319
	3	A	0.26	0.26	0.49	1.41	2.05	0.55	0.12	342

## PACKING

25 kg (bag) : SAP stock number :