

DESCRIPTION

- C-Cr-Mo alloyed agglomerated basic flux for submerged arc strip hardfacing.
- In combination with Soudotape B, Record RT 600 deposits a 0.4 C - 6 Cr - 0.7 Mo in 3 layers to reach a level of hardness of 56HRc.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1.6 (according to Bonizewski; calculated in mole %)
- Grain size 0.25 - 1 mm (18 x 60 Mesh ASTM)
- Apparent density 1
- Consumption 0.9 (kg fused flux / kg strip)
- Redrying 1 to 2 hours at 350°C +/- 50°C
- Applicable strip dimensions :

Strip widths (mm)	30	60	90
Typical deposition rates (kg/h)	8	14	20

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

- Base metal 0.2 %C - steel
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 800 A - 27V - 17 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Mo	Thickness (mm)	Hardness
0.4 C 6 Cr 0.7 Mo	-	B	0.06	0.35	0.04	-	-	-	-
	1	B	-	-	-	-	-	4	-
	2	B	-	-	-	-	-	4	-
	3	B	0.40	0.30	0.90	5.9	0.7	4	56 HRc

PACKING

25 kg (bag) : SAP Stock number : 29194.