

## DESCRIPTION

- Alloyed agglomerated flux for submerged arc strip hard surfacing of rolls.
- Allows to deposit a 410NiMoNbV alloy in 3 layers.

## GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1.4 ( according to Bonizewski; calculated in mole % )
- Grain size 0.4 – 1.4 mm ( 14 x 40 N° ASTM )
- Apparent density 1.1
- Consumption 0.8 ( 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)	7	13	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 – 27 V – 13 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Nb	V	Thickn. (mm)	Hardness (HRC)
410NiMoNbV	-	430	0.045	0.42	0.26	16.30	0.14	0.02	0.02	-	-	-
	1	430	0.085	0.35	0.75	12.00	2.00	0.90	0.10	0.10	3	40
	2	430	0.095	0.30	0.85	13.00	2.30	0.90	0.10	0.10	3	41
	3	430	0.095	0.25	0.90	13.50	2.40	1.00	0.10	0.10	3	42

## PACKING

25 kg (pail) : SAP stock number: 64294