

DESCRIPTION

- Non-alloyed agglomerated flux for submerged arc strip cladding depositing a mild steel alloy in combination with Soudotape A.
- Buffer layer deposit prior to cladding.
- Improves the weldability of hard-to-weld steels by depositing 1 or 2 layers of metal with low carbon.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 0.8 (according to Bonizewski; calculated in mole %)
- Grain size 0.4-1.4 mm (14x40 Mesh ASTM)
- Apparent density 1.15
- Consumption 0.85 (kg fused flux / kg strip)
- Redrying 1 to 2 hours at 350 +/- 50°C
- Approvals TUV(with Soudotape A)
- 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 0.2%C - steel
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 1250A -28V -15cm/min

Alloy	Layer	Strip Soudotape	C	Mn	Si	Thickn. (mm)	Hardness
Mild steel	-	A	0.03	0.2	0.02	-	-
	3	A	0.06	0.9	0.50	4.8	150 HB
	4	A	0.04	1.0	0.50	4.8	150 HB

PACKING

- 25 kg (pail) : SAP Stock number: 29173.
25 kg (bag) : SAP Stock number: 29174.