

DESCRIPTION

- Strip allowing to deposit by Arc submerged or Electroslag cladding a 20Cr-25Ni-5Mo LCu alloy (904L alloy).
- Very high pitting resistant equivalent.
- Highly resistant against sulphur-, phosphorous-, acetic- and formic acid.
- Caused from the low C-content of the weld metal, the risk of intergranular corrosion can be avoided.

SUITABLE FOR

- Specially suitable in sulphuric- and phosphoric acid solutions, pulp and paper industry, flue gas desulphurisation plants, further on for chemical fertilizer production processes, petrochemical industry...

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

- Submerged arc strip cladding with Record INT 101 on 0.2% C-steel.

Two layers deposit	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	Cu	Thickn. [mm]
SOUDOTAPE 20.25.5 LCu		0.012	1.6	0.30	19.9	24.3	4.3	1.5	
1 st Layer	INT 101	0.05	1.6	0.70	16.3	21.2	3.7	1.2	4.0
2 nd Layer	INT 101	0.03	1.7	0.80	18.8	24.0	4.1	1.4	3.8

- Electroslag strip cladding with Record EST 122 (two layers) on 0.2% C-steel.

Two layers deposit	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	Cu	Thickn. [mm]
SOUDOTAPE 20.25.5 LCu		0.012	1.6	0.30	19.9	24.3	4.3	1.5	
1 st Layer	EST 122	0.03	1.40	0.40	17.40	22.70	4.10	1.30	4.2
2 nd Layer	EST 122	0.02	1.4	0.50	19.5	24.2	4.2	1.45	4.0

- Electroslag strip cladding with Record EST 385-1 (one single layer) on 0.2% C-steel.

Two layers deposit	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	Cu	Thickn. [mm]
SOUDOTAPE 20.25.5 LCu		0.012	1.6	0.30	19.9	24.3	4.3	1.5	
1 st Layer	EST 385-1	0.015	2.5	0.1	19.4	25.0	4.4	1.33	5

AVAILABLE STRIP SIZES

- Standard : 90 x 0.5 mm, 60 x 0.5 mm or 30 x 0.5 mm.
- Other sizes on request.

PACKING

- 90 x 0.5 mm : 70 kg to 90 kg.
- 60 x 0.5 mm : 50 kg to 60 kg.
- 30 x 0.5 mm : 25 kg to 30 kg.

- Other packing on request.

Note : For additional information about cladding conditions and deposited weld metal properties, please refer to the corresponding flux technical data sheet, cladding data sheet or contact us.