

DESCRIPTION

- SOUDOTAPE 21.11LNb is a strip designed for single and multi layer electroslag strip cladding of the 347 alloy.
- SOUDOTAPE 347 is TÜV approved with RECORD EST 122.

SUITABLE FOR

- Petrochemical reactors, Hydrocrackers

TYPICAL STRIP ANALYSIS

C	Mn	Si	Cr	Ni	Nb
0.016	1.8	0.30	21.4	11.3	0.70

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

- Electroslag strip cladding with RECORD EST 122 / EST 136 Mo on a 0.2% C - Steel

	Flux RECORD	C	Mn	Si	Cr	Ni	N	Nb	Thickn. (mm)	FN
I st Layer (Alloy 347)	EST 122	0.030	1.40	0.4	19.0	10.1	0.030	0.50	4.8	7
I st Layer (Alloy 347)	EST 136	0.035	1.25	0.3	18.8	9.7	0.025	0.45	4.2	4
I st Layer (Alloy 347)	EST 129	0.035	1.40	0.3	18.4	9.5	0.030	0.50	4.2	4

APPROVALS

Flux RECORD	TÜV
EST 122	08071.02 KTA 1408.1
EST 122	04615.03

AVAILABLE STRIP SIZES

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

PACKING

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