

DESCRIPTION

- Soudotape 21.13.3L is a strip designed for single layer electrosag strip cladding of 316L alloy.
- This strip can also be used for multilayer cladding of other alloys (ex: 317L) when used with special fluxes such as Record EST 122 Mo, Record EST 136 or Record EST 136 Mo, EST 317-1 and EST 130 for a 318 alloy.
- Soudotape 21.13.3L can also be used for SAW strip cladding using flux Record INT 101 Mo.

SUITABLE FOR

- Used in a wide variety of industries such as chemical, petrochemical...
- Generally used to obtain 316L and 317L weld overlays.

STRIP ANALYSIS

Strip designation	C	Mn	Si	Cr	Ni	Mo
SOUDOTAPE 21.13.3L	0.014	1.7	0.3	20.3	14.2	2.9

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

- Submerged arc strip cladding with RECORD INT 101 Mo on a 0.2% C - Steel

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	Thickn. (mm)	FN
1 st Layer (Alloy 317L)	INT 101 Mo	0.041	1.43	0.68	17.9	11.5	2.81	4.7	7.3

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

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	N	Nb	Thickn. (mm)	FN
1 st Layer (Alloy 316 L)	EST 122	0.025	1.3	0.40	18.2	12.6	2.6	-	-	5.0	6
2 nd Layer (Alloy 317L)	EST 136 Mo	0.021	1.3	0.30	18.2	13.3	3.3	-	-	3.8	6.6
1 st Layer (Alloy 317 L)	EST 317-1	0.022	1.1	0.20	18.5	13.4	3.2	0.030	-	4.0	7
1 st Layer (Alloy 318 L)	EST 130	0.030	1.3	0.30	18.0	12.2	2.6	0.030	0.30	1.7	5.8

APPROVALS (IN COMBINATION WITH FLUX)

RECORD	TÜV
EST 122	09411.00

AVAILABLE STRIP SIZES

- Standard: 60 x 0.5 mm or 30 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.