

DESCRIPTION

- Soudotape 22.6.3L is a strip designed for single layer electrosag strip cladding of duplex alloy.
- This strip can also be used for multilayers cladding of duplex alloy in ESW or in SAW in combination with specific flux.

SUITABLE FOR

- Heat exchangers

TYPICAL STRIP ANALYSIS

C	Mn	Si	Cr	Ni	Mo	N
0.02	1.4	0.3	22.5	5.5	3.2	0.160

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

- Submerged arc strip cladding with RECORD INT 110 on a 0.2% C – Steel.

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	N	Thickn. (mm)	FN
3 rd Layer	INT 110	0.02	0.9	1.0	21.7	6.6	2.9	0.15	3.3	60

- Electrosag strip cladding with RECORD EST 122 on a 0.2% C – Steel.

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	N	Thickn. (mm)	FN
2 nd Layer	EST 122	0.03	1.38	0.44	20.9	5.3	2.70	0.15	4.8	67

- Single layer electrosag strip cladding with RECORD EST 4462-1 on a 0.2% C – Steel.

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	N	Thickn. (mm)	FN
1 st Layer	EST 4462-1	0.033	1.0	0.40	21.8	7.3	2.90	0.110	4.5	36

AVAILABLE STRIP SIZES

- Standard : 30 x 0.5 mm, 60 x 0.5 mm and 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.