

ASME II C SFA 5.9 :	EQ 309 LNb
EN ISO 14343-A :	B 23 12 Nb
DIN 8556 :	UP X2CrNiNb 24 12
W-Nr. :	1.4556

DESCRIPTION

- Soudotape 24.12 LNb is a strip designed for single layer electroslag strip cladding of 347 alloy.
- This strip can also be used for multilayers cladding of 347 alloy in SAW in combination with specific flux such as Record INT 102 for stabilised stainless steel grades.

SUITABLE FOR

- Petrochemical reactors, Hydrocrackers,

TYPICAL STRIP ANALYSIS

C	Mn	Si	Cr	Ni	N	Nb
0.17	2.1	0.4	23.7	12.5	0.05	0.70

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

- Submerged arc strip cladding with RECORD INT 102 on a 0.2% C – Steel.

	Flux RECORD	C	Mn	Si	Cr	Ni	N	Nb	Thickn. (mm)	FN
1 st Layer (Alloy 347)	INT 109	0.050	0.8	0.80	18.6	10.0	0.04	0.30	3.3	4

- Electroslag strip cladding with RECORD EST 136 on a 0.2% C – Steel.

	Flux RECORD	C	Mn	Si	Cr	Ni	N	Nb	Thickn. (mm)	FN
1 st Layer (Alloy 347)	EST 136	0.045	1.4	0.4	19.3	10.5	0.04	0.5	3.1	5

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.