

ASME II C SFA 5.9 : -
EN 12072 : -
EN ISO 14343-A : -
EN ISO 14343-B : -

DESCRIPTION

- SOUDOTAPE 258 is a strip designed for single and multilayer sub-arc & electroslag strip cladding of 0.2C-6Cr-1.5Mo-1.5W alloy.

SUITABLE FOR

- Continuous casting rollers, steel mills...

TYPICAL STRIP ANALYSIS

C	Mn	Si	Cr	Ni	Mo	W
0.33	1.1	0.4	6.8	0.4	1.7	1.7

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

- Submerged arc strip cladding of SOUDOTAPE 258 with RECORD RT 159 on a 0.2% C - Steel

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	W	Thickn. (mm)	Hardness [HRC]
2 nd Layer (Alloy 0.2C-6Cr-1.5Mo-1.5W)	RT 159	0.25	1.0	0.5	6.4	0.3	1.3	1.55	3.2	45
3 rd Layer (Alloy 0.2C-6Cr-1.5Mo-1.5W)	RT 159	0.25	1.0	0.5	6.6	0.3	1.6	1.60	3.2	50

- Electroslag strip cladding of SOUDOTAPE 258 with RECORD EST 122 on a 0.2% C - Steel

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	W	Thickn. (mm)	Hardness [HRC]
1 st Layer (Alloy 0.2C-6Cr-1.5Mo-1.5W)	EST 122	0.25	1.0	0.5	5.4	0.2	1.3	1.35	5	45
2 nd Layer (Alloy 0.2C-6Cr-1.5Mo-1.5W)	EST 122	0.25	1.0	0.6	6.4	0.3	1.5	1.55	4.8	45

AVAILABLE STRIP SIZES

- Standard : 30 x 0.5 mm or 60 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.
- 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.