

ASME II C SFA 5.9 : EQ 308L
 EN ISO 14343-A : B 19 9 L
 EN ISO 14343-B : BS308L

DESCRIPTION

- SOUDOTAPE 308L is a strip designed for single and multilayer sub-arc & electroslag strip cladding of 308L and 307 alloys.
- This strip can be used in combination with RECORD INT 101 & 109 for sub-arc strip cladding as well as with RECORD EST 122, 136, 307 and 308-1 for electroslag strip cladding applications.

SUITABLE FOR

- Chemical, petrochemical & corrosion resistant applications, steel industry,...

TYPICAL STRIP ANALYSIS

C	Mn	Si	Cr	Ni
0.013	1.7	0.4	20.3	10.4

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

- Submerged arc strip cladding of SOUDOTAPE 308L with RECORD INT 101 / INT 109 on a 0.2% C - Steel

	Flux RECORD	C	Mn	Si	Cr	Ni	Thickn. (mm)	FN
2 nd Layer (Alloy 308L)	INT 101	0.022	1.6	0.80	19.7	10.2	4.1	7
2 nd Layer (Alloy 308L)	INT 109	0.03	1.0	0.8	19.5	10.2	4.2	6

- Electroslag strip cladding of SOUDOTAPE 308L with RECORD EST 122 / EST 136 / EST 308-1 & EST 30 on a 0.2% C - Steel

	Flux RECORD	C	Mn	Si	Cr	Ni	N	Thickn. (mm)	FN
2 nd Layer (Alloy 308L)	EST 122	0.020	1.40	0.60	19.3	10.2	-	4.5	8
2 nd Layer (Alloy 308L)	EST 136	0.025	1.3	0.4	19.0	9.90	-	3	6
1 st Layer (Alloy 308L)	EST 308-1	0.024	1.28	0.42	19.8	10.0	0.029	4	7
2 nd Layer (Alloy 18Cr 8Ni 6Mn)	EST 307	0.071	5.30	0.55	18.60	9.20	-	4.5	-

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.