

ASME II C SFA 5.9 : EQ 420  
EN ISO 14343-B : BS 420

## DESCRIPTION

- Martensitic 13%Cr strip designed for multi-layers cladding of the 410/420 family alloys.
- SOUDOTAPE 420 can be used in combination with RECORD RT 159 (submerged arc strip cladding) , with RECORD EST 420 (electroslag strip cladding) , with RECORD EST 423 (electroslag strip cladding) or with RECORD EST 426 (electroslag strip cladding) .

## SUITABLE FOR

- Continuous casting rolls, milling rolls, hardfacing applications in steelworks,...

## TYPICAL STRIP ANALYSIS

Strip designation	C	Mn	Si	Cr
SOUDOTAPE 420	0.33	0.4	0.4	13.6

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

- Submerged arc strip cladding with RECORD RT 159 on a 0.2% C - Steel
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 750A – 28V – 12cm/min – 150°C

Layer	Flux RECORD	C	Mn	Si	Cr	Thickn. (mm)	Hardness
1	RT 159	0.19	0.24	0.7	9.20	3.80	45HRc
2	RT 159	0.20	0.2	0.8	11.6	3.60	45HRc
3	RT 159	0.20	0.2	0.80	12.2	3.50	50Hrc

- Electroslag strip cladding with RECORD EST 426 on a 0.2% C – Steel
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 1400A – 24V – 24cm/min – 150°C

Layer	Flux RECORD	C	Mn	Si	Cr	Thickn. (mm)	Hardness
1	EST 426	0.29	0.4	0.4	10.6	4.4	50HRc
2	EST 426	0.31	0.3	0.2	12.6	4.2	50HRc

- Electroslag strip cladding with RECORD EST 423 on a 0.2% C – Steel
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 1250A – 24V – 17cm/min – 150°C

Layer	Flux RECORD	C	Mn	Si	Cr	Mo	Thickn. (mm)	Hardness
1	EST 423	0.27	0.4	0.2	10.5	1.4	4.3	50HRc
2	EST 423	0.28	0.2	0.1	12.8	1.8	4.2	50Hrc
3	EST 423	0.29	0.3	0.1	12.9	1.8	4.2	50HRc

## AVAILABLE STRIP SIZES

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