

ASME II C SFA 5.14 : -
EN ISO 18274 : -

DESCRIPTION

- Unalloyed strip for low alloyed overlaying for submerged arc welding.

SUITABLE FOR

- Rolls, casting rollers, buffer layer,...

TYPICAL STRIP ANALYSIS

C	Mn	Si
0.025	0.2	0.01

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

- Submerged arc strip cladding of SOUDOTAPE A on a 0.2% C - Steel

	Flux RECORD	C	Mn	Si	Cr	Mo	Ni	Hardness
2 nd Layer (Unalloyed steel)	S 46 T	0.055	1	0.5	-	-	-	150 HB
2 nd Layer (Unalloyed steel)	RT 146 TW	0.055	1	0.5	-	-	-	150 HB
3 rd Layer (3 Cr – 0.5 Mo)	RT 250	0.08	0.7	0.7	3	0.4	-	290 HB
3 rd Layer (5 Cr – 0.9 Mo)	RT 350	0.08	0.3	0.3	5	0.9	-	325 HB
4 th Layer (6 Cr – 1 Mo)	RT 400 D	0.12	0.3	0.4	5.8	0.9	-	40 HRC
3 rd Layer (6 Cr – 3 Mo)	RT 500	0.34	0.26	0.33	6.02	-	2.96	51 HRC

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.