

ASME II C SFA 5.14 :EQ NiCrMo-13
EN ISO 18274 : BNi 6059 (NiCr23Mo16)

DESCRIPTION

- SOUDOTAPE NiCrMo 59 is a welding strip especially designed to deposit alloy 59 in combination with Record EST 259.

SUITABLE FOR

In case of alloy 59, it is employed primarily for welding components in environmental plants and plants for chemical processes with highly corrosive media. Excellent resistance against pitting, crevice corrosion and chloride-induced stress corrosion cracking. In addition to its exceptional resistance to contaminated oxidizing mineral acids, acetic acids and acetic anhydrides, hot contaminated sulphuric and phosphoric acid. Weld with possibly low heat input and low interpass temperature.

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

Electroslag strip cladding with Record EST 259 on 0.2% C-steel.

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	Fe
SOUDOTAPE NiCrMo 59		0.005	0.2	0.04	22.7	Bal.	15.5	0.7
1 st Layer	EST 259	0.019	0.2	0.04	20.3	Bal.	14.6	9
2 nd Layer	EST 259	0.01	0.2	0.5	21.8	Bal.	15	3.3

AVAILABLE STRIP SIZES

- Standard : 60 x 0.5 mm or 30 x 0.5 mm.
- Other sizes on request.

PACKING

- 60 x 0.5 mm : 50 kg to 60 kg.
- 30 x 0.5 mm : 25 kg to 30 kg.
- Other packing 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.