

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

RECORD EST 136 Mo is a Fluorid Basic agglomerated flux specifically designed for high productivity Electroslag strip cladding. This advanced welding flux ensures superior performance, especially when combined with SOUDOTAPE 21.13.3L, to achieve the nominal chemical analysis of alloy 317L in two layers.

The high molybdenum content of RECORD EST 136 Mo significantly improves resistance to pitting and crevice corrosion. This is crucial for applications in aggressive marine and chemical environments.

Exceptional slag release, simplifying post-welding clean-up.

Enhanced wetting properties ensure smooth and uniform weld surfaces.

While optimized for high-speed conditions, this flux is equally effective under standard cladding conditions.

RECORD EST 136 Mo is ideal for use with 317L austenitic stainless steel alloy, known for its remarkable corrosion resistance and thermal stability. This makes the flux a preferred choice for industries where material durability and reliability are paramount

317L is an exceptional austenitic stainless steel alloy, renowned for its excellent corrosion resistance and thermal stability. Its unique properties make it an ideal material for demanding industrial applications, ensuring longevity and reliability where material performance is critical.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	4.7
Grain size (EN ISO 14174)	0.25 – 1.0 mm (No. 60 – 18)
Apparent density	0.9
Flux consumption	0.8 (kg fused flux / kg strip)
Redrying	1 to 2 hours at 350 +/- 50°C

Typical strips to combine

Process	Name	ASME II C SFA 5.9	EN ISO 14343-A	EN ISO 14343-B
ESW	SOUDOTAPE 21.13.3L	(EQ309LMo)	B 21 13 3 L	BS309LMoD

Packaging

Type	Weight
Metal drum	25 kg