

## Classifications

EN ISO 14174

ES A FB 2B

## Characteristics and typical fields of application

- Single layer agglomerated Fluoride-basic flux for Electroslag Strip Cladding.
- RECORD ES 6625-1 is designed to produce weld overlay that met requirement for nickel base alloy 625 in single layer.
- With SOUDOTAPE 625 strip electrode, cladding is conform to SFA 5.39 NiCrMo-3 (7% max Fe) with overthickness below 5mm on mild steel or medium alloyed steel grades.
- When compliance of weld overlay with UNS N06625 (5% max Fe) is requested, RECORD EST 625-1LD is recommended.
- Very good weld properties, easy slag release, smooth and shiny overlay surface.
- Best solution for single layer restoration of 625 clad pipes.

## Flux properties

Polarity	DC +
Basicity index (Boniszewski)	4.9
Grain size (EN ISO 14174)	0.25 – 1.0 mm (No. 60 – 18)
Apparent density	1.0
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 5.14	EN ISO 18274
ESW	SOUDOTAPE 625	EQNiCrMo-3	B Ni 6625 (NiCr22Mo9Nb)