

Classifications

EN ISO 14174

S A CS 3

Characteristics and typical fields of application

Agglomerated Calcium-Silicate flux for hard-facing overlay with Cr - Mo additions.

RECORD CrMo22 is designed to produce multiple layer cladding that met requirement for 2,25Cr-1Mo (1.7380 - 10CrMo9-10 - SA 387 Gr.22) steel designation.

In combination with strip electrode Soudotape A and solid wire Union S1, deposit can reach hardness in the range of 250HB.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	1.3
Grain size (EN ISO 14174)	0.40 – 1.4 mm (No. 40 – 14)
Apparent density	1.1
Flux consumption	0.8 (kg fused flux / kg strip)

Typical strips to combine

Process	Name	AWS A5.17 / SFA-5.17	EN ISO 14171-A	EN ISO 14171-B
SAW	Soudotape A	(EL8)	(S1)	(SU08)
SAW	Union S 1	EL12	S1	