

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

RECORD ES 2209 is a specialized fluoride basic flux designed for Electroslag Strip Cladding, ideal for producing weld overlays that meet the stringent requirements of 2209 duplex stainless steel using the cost-effective SOUDOTAPE 22.6.3L strip electrode in just two layers. Exceptional pitting corrosion resistance weld deposit with a Pitting Resistance Equivalent Number (PREN) > 35.

Superior weldability with excellent wetting characteristics.

Easy slag removal even at elevated interpass temperatures.

Minimizes the risk of weld defects such as hot cracking.

Superior resistance to stress corrosion cracking, pitting, and crevice corrosion, especially in chloride-rich environments.

Suitable for various environments and applications, including oil and gas, chemical processing, marine engineering, and construction, making it an ideal choice for demanding applications.

By choosing **RECORD ES 2209**, industries can achieve enhanced performance, durability, and cost savings, providing a highly effective solution for challenging environments.

Flux properties

Polarity	DC+
Basicity index (Boniszewski)	3.6
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°C +/- 50°C

Typical strips to combine

Process	Name	ASME II C SFA 5.9	EN ISO 14343-A	EN ISO 14343-B
ESW	SOUDOTAPE 22.6.3L	(EQ2209)	B Z 22 6 3 N L	BS(2209)