

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

Highly basic alloyed agglomerated flux specifically developed for single layer Electroslag strip cladding of modified Super Duplex 25 % chromium, **9% nickel**, 4 % molybdenum (AWS 5.39 2594) using SoudotaPE 25.8.4L strip.

Excellent pitting corrosion resistance PREN>40

Excellent weldability and good wetting characteristics.

Easy slag removal even at high temperatures.

Flux properties

Polarity	DC+
Basicity index (Boniszewski)	5.3
Grain size (EN ISO 14174)	0.25 – 1.0 mm (No. 60 – 18)
Apparent density	1.0
Flux consumption	0.75 (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 25.8.4L	(EQ2594)	B Z 25 8 4 N L	BS(2594)