RECORD EST 825H HS

Flux for Electroslag strip cladding, nickel base alloys

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

Agglomerated Fluoride-Basic flux developed for Electroslag Strip Cladding
RECORD EST 825H HS is designed to produce Alloy 825 (2.4858 - NiFeCr-1) with strip electrode SOUDOTAPE 825HS.
Developed as a productive, 2-layers weld overlay solution, allowing deposit of minimum thickness even with high travel speed
Well-adapted for strip cladding of very large vessels in combination with strip electrode of 90 mm width.
RECORD EST 825H HS is well adapted for single layer weld overlay with SOUDOTAPE 825HS, when nickel requirement is 38% minimum.

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	0.8 (kg fused flux / kg strip)
Redrying	1 to 2 hours at 350°C +/- 50°C
Moisture content (AWS A4.4M: 2001; 1050 °C)	<0.2

Typical strips to combine

Process	Name	ASME II C SFA 5.14	EN ISO 18274
ESW	SOUDOTAPE 825HS	EQNiFeCr-1	B Ni 8065 (NiFe30Cr21Mo3)

Packaging

Type	Weight
Metal drum	25 kg