

Classifications

EN ISO 14174

S A AF 2B

Characteristics and typical fields of application

- Agglomerated basic flux for Submerged Arc strip cladding with SOUDOTAPE 690 in multi layer for nuclear power plant steam generators tube sheets.
- Especially developed to reach the chemical analysis of alloy 690 in minimum 3 layers with SOUDOTAPE 690.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	1.7
Grain size (EN ISO 14174)	0.40 – 1.4 mm (No. 40 – 14)
Apparent density	1.0
Flux consumption	1.0 (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
SAW	SOUDOTAPE 690	EQNiCrFe-14	B Ni 6043 (NiCr30Fe9Nb2)

Packaging

Type	Weight
Metal drum	25 kg