RECORD NFT NiCrFe7

Flux for Submerged Arc strip cladding, nickel base alloys

Classifications

EN ISO 14174

S A AB 2B

Characteristics and typical fields of application

• Agglomerated Aluminate-Basic flux developed for Submerged Arc Strip Cladding to meet nickel-chromium-iron weld overlays on steel comparable to UNS number N06690.
• RECORD NFT NiCrFe7 is designed to produce multiple layer cladding that meet requirement for SFA 5.39 NiCrFe-7 deposit with SOUDOTAPE NiCrFe7.
• The nominal composition (wt %) of weld metal produced by this combination is 55 Ni. 29 Cr. 9.5 Fe. 3 Mn. and 1.5 Nb plus Ta
• Weld deposits made with this composition are particularly resistant to ductility-dipcracking (DDC).
• This UTP combination is qualified for Alloy 690 steam generators heat exchanger in nuclear power plant.
• The same combination is applicable for high temperature applications in petrochemical industry, burners and furnaces.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	1.5
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
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
SAW	SOUDOTAPE NiCrFe7	EQNiCrFe-7	B Ni 6052 (NiCr30Fe9)

Packaging

Type	Weight
Metal drum	25 kg