

Classifications

EN ISO 14174

S A CS 3

Characteristics and typical fields of application

- Agglomerated flux for Submerged Arc strip surfacing of continuous casting rolls.
- Especially developed to clad a supermartensitic 13Cr-5Ni-2,5MoL alloy on small continuous casting rolls in combination with SOUDOTAPE 430L 30x0.5mm

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	0.96
Grain size (EN ISO 14174)	0.40 – 1.4 mm (No. 40 – 14)
Apparent density	1.1
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 5.9	EN ISO 14343-A	EN ISO 14343-B
SAW	SOUDOTAPE 430L	EQ430	B 17	BS430

Packaging

Type	Weight
Bag	25 kg