

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

- Agglomerated Fluoride-basic flux with chromium and nickel additions developed for Electroslag Strip Cladding.
- RECORD EST 309-1 in combination with strip electrode Soudotape 309L to produce single layer cladding that met requirement for low carbon austenitic stainless steel 309L (1.4332) designation
- Excellent weldability and good wetting behaviour.
- Easy slag release even at high temperatures.

Flux properties

Basicity index (Boniszewski)	5.2
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)
Moisture content (AWS A4.4M: 2001; 1050 °C)	<0.2

Typical strips to combine

Process	Name	ASME II C SFA 5.9	EN ISO 14343-A	EN ISO 14343-B
ESW	Soudotape 309L	EQ309L	B 23 12 L	BS309L

Packaging

Type	Weight
Metal drum	25 kg