

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

High basic compensating agglomerated flux for ElectroSlag Strip Cladding

Most efficient solution to get UNS N08904 (1.4539 - ALLOY 904L) in single layer with SOUDOTAPE 20.25.5LCu.

Excellent weldability and good wetting behaviour.

Easy slag release.

High molybdenum addition gives superior resistance to pitting and crevice corrosion by chloride. Copper addition gives it useful corrosion resistance to sulphuric acid.

Low carbon content makes this solution resistant to sensitization and prevents intergranular corrosion.

Typical Applications

Processing plant for sulphuric, phosphoric and acetic acids in chemical industry.

Chemical fertilizer production processes.

Pulp and paper processing industry.

Seawater cooling equipment.

Oil refinery components

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	5
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 +/- 50°C
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 20.25.5LCu	EQ385	B 20 25 5 Cu L	BS385

Packaging

Type	Weight
Metal drum	25 kg (pail)