

Classifications

EN ISO 14174

ES A FB 3

Characteristics and typical fields of application

- Agglomerated Fluoride-basic electroslag flux for hard-facing overlay with nickel & molybdenum additions.
- In combination with 17%Cr ferritic stainless steel strip electrode SOUDOTAPE 430, RECORD EST 452 is designed to produce multiple layer cladding that met requirement for low carbon 13%Cr-4%Ni-1%Mo martensitic stainless steel (F6MN ; X3CrNiMo13-4 ; 1.4313 ; 415) with hardness in the range of 40HRC from second layer.
- In combination with martensitic stainless steel strip electrode SOUDOTAPE 420, high carbon 13%Cr - 3%Ni -0.5%Mo martensitic stainless steel to met hardness in the range of 50HRC from second layer.
- Excellent weldability and easy slag release even at high interpass temperatures.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	4.1
Grain size (EN ISO 14174)	0.25 – 1.0 mm (No. 60 – 18)
Apparent density	0.9
Flux consumption	0.8 (kg fused flux / kg strip)
Redrying	1 to 2 hours at 350°C +/- 50°C

Typical strips to combine

Process	Name	ASME II C SFA 5.9	EN ISO 14343-A	EN ISO 14343-B
ESW	SOUDOTAPE 420	EQ420	"B 13 H"	BS420
ESW	SOUDOTAPE 430	EQ430	B 17	BS430

Packaging

Type	Weight
Tinplate Pail	25 kg