

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

- Single layer agglomerated Fluoride-basic flux for Electroslag Strip Cladding.
- RECORD EST 625-1 LD is the expert preferred solution to produce weld overlay that met requirement for nickel base alloy 625 (2.4856) in single layer.
- With SOUDOTAPE 625, cladding is conform to SFA 5.39 NiCrMo-3 (7% max Fe) with overthickness below 4mm on mild steel or medium alloyed steel grades.
- Alloy 625 chemical composition with Fe < 10% requirement is met in a thin single layer compared with the conventional solution and allowing to save significant consumable quantities.
- Alloy 625 (UNS 06625) chemical composition with Fe < 5% requirement is achievable in a single layer.
- Very good welding characteristics, easy slag release and a nice bead aspect.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	7.6
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°C +/- 50°C

Typical strips to combine

Process	Name	ASME II C SFA 5.14	EN ISO 18274
ESW	SOUDOTAPE 625	EQNiCrMo-3	B Ni 6625 (NiCr22Mo9Nb)

Packaging

Type	Weight
Tinplate Pail	25 kg