

Classifications

EN ISO 14174

SA - FB 2

Characteristics and typical fields of application

RECORD NiCrW 3000 is a flux for Submerged Arc welding with Nickel-base 625 wire electrodes.

The flux has a relative high basicity with a neutral alloying characteristics and has been optimised to give best operative characteristics with good mechanical properties for LNG applications. It is especially recommended for cladding applications with wire, where a nice bead appearance with perfect slag detachability is mandatory. Applications are found in the oil & gas industry as well as for equipment in chemical and petrochemical industry.

Flux properties

Polarity	DC +/- / AC 900 A max
Basicity index (Boniszewski)	2.3 (according to Boniszewski; calculated in mole %)
Grain size (EN ISO 14174)	4-14 (0.4-1.4 mm)
Apparent density	1.0 kg/hour
Flux consumption	1.2 (kg fused flux / kg wire)
Redrying	350 – 400°C. min 2 hrs ; max 3 cycles

Composition of sub-arc welding flux

	SiO ₂ +TiO ₂	Al ₂ O ₃ +MnO	CaF ₂ +MgO
wt. %	8 %	35 %	55 %

Packaging

Type	Weight
Metal drum	25 kg