

Classifications								
EN ISO 14343-A			EN ISO 14343-B			ASME II C SFA 5.9		
B 23 12 Nb			BS309LNb			"EQ309LNb"		
Characteristics and typical fields of application								
<p>SOUDOTAPE 24.12LNb is a niobium stabilized stainless steel strip developed for single layer ESSC of alloy 347 at high travel speed or very low thickness on carbon and low alloyed steels.</p> <p>In combination with RECORD EST 347-1 HS, this is the best combination for highest productivity and lowest overthickness SOUDOTAPE 24.12LNb is also a good choice for buffer layer when better corrosion resistance is requested.</p> <p>This strip can also be used for SASC multilayers of alloy 347 in combination with SOUDOTAPE 347 and RECORD INT 109. RECORD INT 109 is a submerged arc welding flux specifically designed for Niobium stabilized stainless steel grades.</p> <p>Intergranular corrosion resistance according to ASTM A262 practice E is excellent even after long post weld heat treatment Suitable for high temperature corrosion resistant weldoverlay of prochemical reactors, hydrocrackers and nuclear industry.</p>								
Typical analysis								
	C	Si	Mn	Cr	Ni	Nb	N	Fe
wt.-%	0.01	0.4	2.1	23.8	12.4	0.75	0.05	Rem.
Typical fluxes to combine								
Process			Name			EN ISO 14174		
ESW			RECORD EST 136			ES A FB 2B		
ESW			RECORD EST 347-1 HS			ES A FB 2B		
SAW			RECORD INT 109			S A CS 2B		
Packaging								
Size(s) in mm		Type			Weight			
30 x 0,5		Coil			25 - 30 kg			
60 x 0,5		Coil			50 - 60 kg			
90 x 0,5		Coil			75 - 90 kg			
Other sizes and coil weights on request.								