

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

- Highly basic agglomerated flux for Electroslag strip cladding.
- Excellent weldability, good wetting and easy slag release.
- The low dilution and elevated deposition rate make the use of this flux very interesting.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	3.5
Grain size (EN ISO 14174)	0.25 – 1.0 mm (No. 60 – 18)
Apparent density	0.85
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	SOU DOTAPE 20.25.5LCu	EQ385	B 20 25 5 Cu L	BS385
ESW	SOU DOTAPE 21.11LNb	(EQ347)	B 22 12 L Nb	BS309LNbD
ESW	SOU DOTAPE 21.13.3L	(EQ309LMo)	B 21 13 3 L	BS309LMoD
ESW	SOU DOTAPE 22.11L	(EQ309L)	B 22 11 L	BS309LD
ESW	SOU DOTAPE 22.6.3L	(EQ2209)	B Z 22 6 3 N L	BS(2209)
ESW	SOU DOTAPE 22.9.3L	EQ2209	B 22 9 3 N L	BS2209
ESW	SOU DOTAPE 254SMo	"EQ254SMo"	B Z 20 18 7 Cu N L	
ESW	SOU DOTAPE 308L	EQ308L	B 19 9 L	BS308L
ESW	SOU DOTAPE 309L	EQ309L	B 23 12 L	BS309L
ESW	SOU DOTAPE 310MM	"EQ310LMo"	B 25 22 2 N L	
ESW	SOU DOTAPE 316L	EQ316L	B 19 12 3 L	BS316L
ESW	SOU DOTAPE 317L	EQ317L	B 19 13 4 L	BS(317L)
ESW	SOU DOTAPE 347	EQ347	B 19 9 Nb	BS347

Packaging

Type	Weight
Metal drum	25 kg