

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

- High productivity neutral agglomerated Fluoride-Basic flux developed for Electroslag Strip Cladding
- RECORD EST 136 is designed to produce multiple layer cladding that met requirement of most stainless steels with austenitic strip electrode.
- When high speed conditions are not achievable, this flux is perfectly suitable to weld-overlay with thin over thickness request
- Excellent slag release and good wettability with the base metal.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	4.4
Grain size (EN ISO 14174)	0.25 – 1.0 mm (No. 60 – 18)
Apparent density	0.8
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 21.13.3L	(EQ309LMo)	B 21 13 3 L	BS309LMoD
ESW	SOU DOTAPE 24.12LNb	"EQ309LNb"	B 23 12 Nb	BS309LNb
ESW	SOU DOTAPE 308L	EQ308L	B 19 9 L	BS308L
ESW	SOU DOTAPE 309L	EQ309L	B 23 12 L	BS309L
ESW	SOU DOTAPE 316L	EQ316L	B 19 12 3 L	BS316L
ESW	SOU DOTAPE 347	EQ347	B 19 9 Nb	BS347

Packaging

Type	Weight
Metal drum	25 kg