

## Classifications

EN ISO 14174

ES A FB 2B

## Characteristics and typical fields of application

Neutral agglomerated Fluoride-Basic flux developed for Electroslag Strip Cladding

RECORD EST 201 is designed to produce multiple layer cladding that met requirement of nickel base alloys.  
The low Si-content in the weld metal assures a very low hot cracking sensitivity.  
Excellent weldability and wetting action, easy slag release.

## Flux properties

Polarity	DC +
Basicity index (Boniszewski)	4.4
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 +/- 50°C
Moisture content (AWS A4.4M: 2001; 1050 °C)	<0.2

## Typical strips to combine

Process	Name	ASME II C SFA 5.14	EN ISO 18274
ESW	SOU DOTAPE 625	EQNiCrMo-3	B Ni 6625 (NiCr22Mo9Nb)
ESW	SOU DOTAPE 825HS	EQNiFeCr-1	B Ni 8065 (NiFe30Cr21Mo3)
ESW	SOU DOTAPE NiCr3	EQNiCr-3	B Ni 6082 (NiCr20Mn3Nb)

## Packaging

Type	Weight
Metal drum	25 kg