

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

- Highly basic agglomerated flux especially developed for high speed Electroslag strip cladding with SOUDOTAPE NiCr3 and SOUDOTAPE 625.
- The special formulation of the flux assures good wettability and excellent slag release.
- If high speed conditions are not possible, this flux is perfectly suitable for the standard cladding conditions.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	5.9
Grain size (EN ISO 14174)	0.25 – 1.0 mm (No. 60 – 18)
Apparent density	0.9
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	SOUDOTAPE 625	EQNiCrMo-3	B Ni 6625 (NiCr22Mo9Nb)
ESW	SOUDOTAPE NiCr3	EQNiCr-3	B Ni 6082 (NiCr20Mn3Nb)

Packaging

Type	Weight
Metal drum	25 kg