

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

RECORD EST 307 : fluoride-basic agglomerated flux for Electroslag Strip Cladding (ESSC) designed to produce weld overlay meeting the requirements for 18% Cr - 8% Ni - 5% Mn stainless steel (18 8 Mn; 1.4370; ~307).

With SOUDOTAPE 309L : Achieves high manganese stainless steel 18 8 Mn in a single layer.

With SOUDOTAPE 308L : Achieves high manganese stainless steel 18 8 Mn starting from the second layer.

Applications : Suitable for use in rails, crossovers, armour plates, and high manganese steels.

Enhanced Hardness : Higher manganese content contributes to greater hardness, improving wear resistance and longevity.

High Deposition Rate : Exceeds 11 kg/h using a 30 mm strip electrode, making it highly efficient for rail end surfacing.

Excellent Weldability : Ensures strong, reliable welds with good wetting properties.

Easy Slag Release : Slag releases easily, even at high interpass temperatures, facilitating smoother welding operations.

RECORD EST 307, in combination with SOUDOTAPE 309L or 308L, provides a robust solution for producing high manganese stainless steel overlays. Its high deposition rate, enhanced hardness, excellent weldability, and easy slag release make it ideal for demanding applications, ensuring durability and efficiency across various industrial sectors.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	4.2
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

Typical strips to combine

Process	Name	ASME II C SFA 5.9	EN ISO 14343-A	EN ISO 14343-B
ESW	SOUDOTAPE 308L	EQ308L	B 19 9 L	BS308L
ESW	SOUDOTAPE 309L	EQ309L	B 23 12 L	BS309L

Packaging

Type	Weight
Metal drum	25 kg