

## Classifications

EN ISO 14174

ES A FB 2B

## Characteristics and typical fields of application

- Agglomerated Fluoride-basic flux with chromium, nickel and molybdenum additions developed for Electroslag Strip Cladding.
- RECORD EST 316-1 in combination with strip electrode SOUDOTAPE 316L to produce single layer cladding that met requirement for low carbon austenitic stainless steel 316L (1.4404) designation
- Excellent weldability and good wetting characteristics.
- Easy slag release even at high temperatures.

## Flux properties

Polarity	DC +
Basicity index (Boniszewski)	5.1
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 5.9	EN ISO 14343-A	EN ISO 14343-B
ESW	SOUDOTAPE 21.13.3L	(EQ309LMo)	B 21 13 3 L	BS309LMoD
ESW	SOUDOTAPE 316L	EQ316L	B 19 12 3 L	BS316L

## Packaging

Type	Weight
Metal drum	25 kg