

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 317-1 in combination with strip electrode SOUDOTAPE 21.13.3L to produce single layer cladding that met requirement for 317L (18 15 3 L ; ~1.4438) low carbon austenitic stainless steel designation.
- Excellent weldability and good wetting behaviour.
- 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

Packaging

Type	Weight
Metal drum	25 kg