

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

- Agglomerated fluoride-basic flux for Electroslag Strip Cladding of Duplex stainless steel in single layer.
- RECORD EST 4462-1 in combination with SOUDOTAPE 22.6.3L, to produce single layer cladding that met requirement for 1.4462 (UNS S32205) duplex stainless steel designation.
- RECORD EST 4462-1 in combination with SOUDOTAPE 22.9.3L, to produce single layer cladding that met requirement for 2209 (~UNS S32205) duplex stainless steel designation.
- Contribute to easy slag release and excellent wetting behaviour of weld overlay.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	5.3
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 22.6.3L	(EQ2209)	B Z 22 6 3 N L	BS(2209)
ESW	SOUDOTAPE 22.9.3L	EQ2209	B 22 9 3 N L	BS2209

Packaging

Type	Weight
Tinplate Pail	25 kg