

Classifications

EN ISO 14174

ES A FB 3

Characteristics and typical fields of application

- Agglomerated Fluoride-basic electroslag flux with molybdenum additions for hard-facing overlay.
- In combination with martensitic stainless steel strip electrode Soudotape 420, high carbon 13%Cr - 2%Mo (~S42026) martensitic stainless steel to meet hardness in the range of 55HRC from second layer.
- In combination with martensitic strip electrode Soudotape 258, high carbon predominantly martensitic microstructure to meet hardness in the range of 55HRC from second layer.
- The presence of Molybdenum improves properties at high temperature.
- Excellent weldability and easy slag release even at high interpass temperatures.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	4.1
Grain size (EN ISO 14174)	0.25 - 1.0 mm (No. 60 - 18)
Apparent density	0.9
Flux consumption	0.8 (kg Pulver/kg Band)
Redrying	1 bis 2 Stunden bei 350 +/- 50°C

Typical strips to combine

Process	Name	ASME II C SFA 5.21	ASME II C SFA 5.9	EN ISO 14343-A	EN 14700	EN ISO 14343-B
ESW	Soudotape 258	"EQFe-8"			B Fe8	
ESW	Soudotape 420		EQ420	"B 13 H"		BS420

Packaging

Type	Weight
metallic drum	25 kg