RECORD EST 426

Flux for Electroslag strip cladding, stainless and corrosion resistant steels

Classifications

EN ISO 14174

ES A FB 3

Characteristics and typical fields of application

• Neutral agglomerated Fluoride-basic electroslag flux for hard-facing overlay.
• In combination with martensitic strip electrode SOUDOTAPE 258,
high carbon predominantly martensitic microstructure to met hardness in the range of 50HRc from second layer.
• In combination with ferritic stainless sleel strip electrode SOUDOTAPE 410L,
low carbon 12%Cr M+F stainless steel (X6Cr13 ; 1.4000 ; 410S) to met hardness in the range of 200HB from second layer.

• In combination with ferritic stainless sleel strip electrode SOUDOTAPE 430,
low carbon 15%Cr ferritic stainless steel (X6Cr17 ; 1.4016 ; 430) to met hardness in the range of 200HB from second layer.

• In combination with martensitic stainless sleel strip electrode SOUDOTAPE 420,
high carbon 13%Cr martensitic stainless steel (X20Cr13 ; 1.4021 ; 420) to met hardness in the range of 50HRc from second layer.

• Excellent weldability, good wetting and easy slag release.

• Low dilution and high travel speed make elevated deposition rate and productivity at low cost.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	4.6
Grain size (EN ISO 14174)	0.25 – 1.0 mm (No. 60 – 18)
Apparent density	0.85
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 5.21	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 410L		EQ410	B 13 L		BS410
ESW	SOUDOTAPE 420		EQ420	"B 13 H"		BS420
ESW	SOUDOTAPE 430		EQ430	B 17		BS430

Packaging

Type	Weight
Tinplate Pail	25 kg