

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

- Single layer agglomerated Fluoride-basic flux for Electroslag Strip Cladding.
- RECORD EST 625-1 is the most economical solution to produce weld overlay that met requirement for nickel base alloy 625 (2.4856) in single layer.
- With SoudoTAPE 625, cladding is conform to SFA 5.39 NiCrMo-3 (7% max Fe) with overthickness below 4mm on mild steel or medium alloyed steel grades.
- When compliance of weld overlay with UNS N06625 (5% max Fe) is requested, RECORD EST 625-1LD is recommended.
- Allow high deposition rate with cladding speed up to 200mm/min
- The low Si-content in the weld overlay ensure a very low hot cracking sensitivity.
- Very good weld properties, easy slag release, smooth and shiny overlay surface.
- Large and successful experience in tough requirements for petrochemical applications.
- Best solution for single layer restoration of 625 clad pipes.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	4.4
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 5.14	EN ISO 18274
ESW	SoudoTAPE 625	EQNiCrMo-3	B Ni 6625 (NiCr22Mo9Nb)

Packaging

Type	Weight
Tinplate Pail	25 kg