

Classifications

EN ISO 14174

S A AB 2B

Characteristics and typical fields of application

- Agglomerated flux for Submerged Arc strip cladding with Cr-Ni stainless steel strips.
- Recommended for cladding with non-stabilised Cr-Ni stainless steel strips.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	0.89
Grain size (EN ISO 14174)	0.40 – 1.4 mm (No. 40 – 14)
Apparent density	0.9
Flux consumption	1.0 (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
SAW	SOUDOTAPE 20.25.5LCu	EQ385	B 20 25 5 Cu L	BS385
SAW	SOUDOTAPE 21.13.3L	(EQ309LMo)	B 21 13 3 L	BS309LMoD
SAW	SOUDOTAPE 308L	EQ308L	B 19 9 L	BS308L
SAW	SOUDOTAPE 316L	EQ316L	B 19 12 3 L	BS316L

Packaging

Type	Weight
Metal drum	25 kg