

Classifications

EN ISO 14174

S A CS 2B

Characteristics and typical fields of application

- Agglomerated basic flux for Submerged Arc strip cladding with Cr-Ni stainless steel strips.
- Suitable for non-stabilised and stabilised grades.
- Outstanding arc stability over a wide range of welding parameters.
- Excellent slag release and good overlapping between adjacent beads.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	1.5
Grain size (EN ISO 14174)	0.60 – 2.0 mm (No. 30 – 10)
Apparent density	1.0
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	SOU DOTAPE 21.11LNb	(EQ347)	B 22 12 L Nb	BS309LNbD
SAW	SOU DOTAPE 22.9.3L	EQ2209	B 22 9 3 N L	BS2209
SAW	SOU DOTAPE 24.12LNb	"EQ309LNb"	B 23 12 Nb	BS309LNb
SAW	SOU DOTAPE 308L	EQ308L	B 19 9 L	BS308L
SAW	SOU DOTAPE 309L	EQ309L	B 23 12 L	BS309L
SAW	SOU DOTAPE 316L	EQ316L	B 19 12 3 L	BS316L
SAW	SOU DOTAPE 317L	EQ317L	B 19 13 4 L	BS(317L)
SAW	SOU DOTAPE 347	EQ347	B 19 9 Nb	BS347

Packaging

Type	Weight
Metal drum	25 kg