

Classifications

EN ISO 14174

S A AB 2B

Characteristics and typical fields of application

- Agglomerated basic flux for Submerged Arc strip cladding with SOUDOTAPE NiCr3 and SOUDOTAPE 625.
- The low silicon content in the weld metal assures a very low hot cracking sensitivity.
- Very low hydrogen content and favourable low moisture pick-up.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	2.3
Grain size (EN ISO 14174)	0.40 – 1.4 mm (No. 40 – 14)
Apparent density	0.95
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 5.14	EN ISO 18274
SAW	SOUDOTAPE 625	EQNiCrMo-3	B Ni 6625 (NiCr22Mo9Nb)
SAW	SOUDOTAPE NiCr3	EQNiCr-3	B Ni 6082 (NiCr20Mn3Nb)

Packaging

Type	Weight
Metal drum	25 kg