

DESCRIPTION

- Highly basic agglomerated flux designed for hardfacing with cored wires or solid wires.
- Very good slag removal even at high welding intensity levels.
- Suitable with DC or AC.

GENERAL CHARACTERISTICS

- Current DC (+ and -) and AC – 1000 A max.
- Basicity index 3.4 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 N° ASTM)
- Apparent density 0.85
- Consumption 0.65 (kg fused flux / kg wire)
- Redrying 1 to 2 hours at 350 +/- 50°C

TYPICAL ALL-WELD METAL ANALYSIS OF WIRE/FLUX COMBINATION (WEIGHT%)

Wire	C	Mn	Si	Cr	Ni	Mo	Nb	Co	W	V	Fe
Soudor D (EN 756 : S4)	0.08	1.3	0.30	-	-	-	-	-	-	-	-
Soudor DMo (EN 756 : S4Mo)	0.08	1.3	0.30	-	-	0.4	-	-	-	-	-
Soudokay 219 – S	1.00	18.2	0.30	4.7	-	-	-	-	-	-	balance
Soudokay AP – S	0.43	16.3	0.30	13.4	-	-	-	-	-	-	balance
Soudokay 402 – S	0.11	6.6	1.00	18.2	8.6	-	-	-	-	-	balance
Soudokay 258 – SA	0.45	1.6	0.40	5.6	-	1.6	-	-	1.5	-	balance
Soudokay 258L – SA	0.20	1.6	0.30	6.0	-	1.6	-	-	1.5	-	balance
Soudokay 245 – SA	1.30	0.8	1.20	6.0	-	-	8.0	-	1.5	-	balance
Soudokay 255 – S	4.70	0.9	0.70	26.0	-	-	-	-	-	-	balance
Soudokay A43 – S	5.60	0.60	1.20	22.0	-	-	7.0	-	-	-	balance
Soudokay A45 – S	5.50	0.25	0.60	22.0	-	5.1	7.4	-	1.9	1.0	balance
Soudokay Tool Alloy C-S	0.05	0.2	0.60	16.0	balance	16.0	-	-	4.0	-	7.0
Soudokay 410 – SA	0.11	1.3	0.30	12.7	-	-	-	-	-	-	balance
Soudokay 415 – SA	0.12	0.9	0.50	13.0	2.0	1.0	0.2	-	-	0.3	balance
Soudokay 420 – SA	0.25	1.35	0.35	13.0	-	-	-	-	-	-	balance
Soudokay 430C – SA	0.04	0.9	0.50	18.0	-	-	-	-	-	-	balance
Soudokay 461 – SA	0.25	0.95	0.45	11.4	-	1.4	-	1.8	0.9	1.9	balance
Soudokay 740 – SA	0.12	1.1	0.30	12.0	2.3	1.3	0.2	-	-	0.2	balance
Soudokay 410NiMo - SA	0.06	0.7	0.80	12.5	5.0	1.0	-	-	-	-	balance
Soudokay D35 – S	0.15	0.26	0.52	14.6	2.4	-	-	13.8	-	-	balance

TYPICAL PURE WELD METAL PROPRIETIES

Wire	Hardness	Abrasion coefficient	Structure
Soudor D (EN 756 : S4)	180	-	Bainitic
Soudor DMo (EN 756 : S4Mo)	200	-	Bainitic
Soudokay 219 – S	210 HB/WH 450	-	Austenitic
Soudokay AP – S	200 HB/WH 52 HRc	-	Austenitic
Soudokay 402 – S	150 HB/WH 42 HRc	-	Austenitic
Soudokay 258 – SA	56 HRc	-	Martensitic
Soudokay 258L – SA	45 HRc	-	Martensitic
Soudokay 245 – SA	57 HRc	5	Martensitic + austenitic + dispersed NbC carbides
Soudokay 255 – S	59 HRc	0.5	Primary carbides + M ₇ C ₃ eutectics in an austenitic matrix
Soudokay A43 – S	63 HRc	0.3	Primary carbides + eutectics M ₇ C ₃ + nodular Nb + perlite
Soudokay A45 – S	63 HRc	0.2	Hexagonal primary Cr carbides + nodular Nb in an austenitic matrix
Soudokay Tool Alloy C-S	200 HB/WH 400 HB	-	Austenitic
Soudokay 410 – SA	44 HRc	-	Martensite + few ferrite
Soudokay 415 – SA	48 HRc	-	Martensite + 10% of ferrite
Soudokay 420 – SA	53 HRc	-	Martensitic
Soudokay 430C – SA	185 HRc	-	Ferrite + few martensite
Soudokay 461 – SA	46 HRc (2 layers)	-	Martensite + 20% of ferrite
Soudokay 740 – SA	46 HRc (2 layers)	-	Martensite + 10% of ferrite
Soudokay 410NiMo - SA	41 HRc	-	Martensite + 10% of ferrite
Soudokay D35 - S	50 HRc (1 layer)	-	Martensite + 15% of ferrite

PACKING

25 kg (pail) : SAP stock number : 29165

25 kg (bag) : SAP stock number : 29166