

Classifications

EN ISO 14174

SA CS 3

Characteristics and typical fields of application

Neutral Agglomerated Calcium-Silicate flux for Submerged Arc Strip Cladding

RECORD RT 159 is a general purpose flux for continuous casting rollers, steel mills.

In combination with mild steel strip electrode SOUDOTAPE A,

low carbon steel with hardness in the range of 150 HB.

In combination with martensitic strip electrode SOUDOTAPE 258,

high carbon predominantly martensitic microstructure to met hardness in the range of 50HRC from third layer

In combination with ferritic stainless steel strip electrode SOUDOTAPE 410L,

low carbon 13%Cr M-F stainless steel (X6Cr13 ; 1.4000 ; 410S) to met hardness in the range of 250HB from third layer

In combination with ferritic stainless steel strip electrode SOUDOTAPE 430,

low carbon 17%Cr ferritic stainless steel (X6Cr17 ; 1.4016 ; 430) to met hardness in the range of 200HB from third layer

In combination with martensitic stainless steel strip electrode SOUDOTAPE 420,

high carbon 13%Cr martensitic stainless steel (X20Cr13 ; 1.4021 ; 420) to met hardness in the range of 50HRC from third layer

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	1.2
Grain size (EN ISO 14174)	0.40 – 1.4 mm (No. 40 – 14)
Apparent density	1.1
Flux consumption	0.8 (kg fused flux / kg strip)
Redrying	1 to 2 hours at 350 +/- 50°C

Typical strips to combine

Process	Name	ASME II C SFA 5.21	ASME II C SFA 5.9	AWS A5.17 / SFA-5.17	EN ISO 14171-A	EN ISO 14343-A
SAW	SOUDOTAPE 258	"EQFe-8"				
SAW	SOUDOTAPE 410L		EQ410			B 13 L
SAW	SOUDOTAPE 420		EQ420			"B 13 H"
SAW	SOUDOTAPE 430		EQ430			B 17
SAW	SOUDOTAPE A			(EL8)	(S1)	

Packaging

Type	Weight
Bag	25 kg