

ASME II C SFA 5.14 : EQ NiFeCr-1
EN ISO 18274 : B Ni 8065
(NiFe30Cr21Mo3Co3)

DESCRIPTION

- SOUDOTAPE 825 is a strip designed for single layer electroslag strip cladding of alloy 825 in combination with flux EST 138.

SUITABLE FOR

- Chemical processing tanks and vessels for sulphuric & phosphoric acid production, pickling installations, oil & gas piping equipments, wastes of nuclear fuel reprocessing components,...

TYPICAL STRIP ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Fe	Cu
0.01	0.8	0.3	22.6	Bal.	3.1	30.5	2.4

TYPICAL WELD METAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Electroslag strip cladding with RECORD EST 138 on a 0.2% C - Steel

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	Fe	Cu	Thickn. (mm)
1 st Layer (Alloy 825)	EST 138	0.02	0.6	0.6	22.3	Bal.	2.8	33.8	1.5	4.8
2 nd layer (1 st layer with EST 201)	EST 201	0.02	0.7	0.7	19.7	Bal.	2.7	33.8	1.85	4.3

AVAILABLE STRIP SIZES

- Standard : 30 x 0.5 mm or 60 x 0.5 mm.
- Other sizes on request.

PACKING

- 30 x 0.5 mm : 25 kg to 30 kg.
- 60 x 0.5 mm : 50 kg to 60 kg.
- Other sizes on request.

Note : For additional information about cladding conditions and deposited weld metal properties, please refer to the corresponding flux technical data sheet, cladding data sheet or contact us.