

Classifications

EN ISO 14174

S A AB 4

Characteristics and typical fields of application

Agglomerated Aluminate-Basic flux developed for joining and cladding with cupronickel alloys.

In combination with SOUDOTAPE CuNi30 strip electrode produce weld overlay that meet requirement of SFA 5.39 CuNi designation from third layer.

In case of cladding on carbon steel, it is advised to deposit first a NiCu buffer layer with solid wire UP 80 M or strip electrode SOUDOTAPE NiCu7 in combination with submerged arc welding flux RECORD NiCu TW.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	1.0
Grain size (EN ISO 14174)	0.40 – 1.4 mm (No. 40 – 14)
Apparent density	0.75
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 5.7	EN ISO 24373
SAW	SOUDOTAPE CuNi30	EQCuNi	B Cu 7158 (CuNi30Mn1FeTi)
SAW	UTP A 387	ERCuNi	S Cu 7158 (CuNi30Mn1FeTi)

Packaging

Type	Weight
Metal drum	25 kg