

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

- Highly basic agglomerated flux especially developed for Electroslag strip cladding of stabilised stainless steel grades.
- Designed to obtain alloy 318 in single layer with SoudotaPE 21.13.3L as well as in two layers using SoudotaPE 316L .
- Allow to obtain a Niobium stabilised 347 alloy in one layer using SoudotaPE 21.11LNb with optimised Nb/C ratio.
- Excellent slag release and good wettability with the base metal.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	3.4
Grain size (EN ISO 14174)	0.25 – 1.0 mm (No. 60 – 18)
Apparent density	0.85
Flux consumption	0.8 (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 5.9	EN ISO 14343-A	EN ISO 14343-B
ESW	SoudotaPE 21.11LNb	EQ347	B 22 12 L Nb	BS309LNbD
ESW	SoudotaPE 21.13.3L	(EQ309LMo)	B 21 13 3 L	BS309LMoD
ESW	SoudotaPE 308L	EQ308L	B 19 9 L	BS308L
ESW	SoudotaPE 316L	EQ316L	B 19 12 3 L	BS316L

Packaging

Type	Weight
Metal drum	25 kg