

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

Neutral fluoride basic agglomerated flux for Electroslag Strip Cladding of Ni-Cr-Mo Nickel-base Alloys

Alloy 59 (N06059 - 2.4605) with Soudotape NiCrMo59
 Hastelloy C-4 (N06455 - 2.4610) with Soudotape NiCrMo7
 Hastelloy C-22 (N06022 - 2.4602) with Soudotape NiCrMo22
 Hastelloy C-276 (N10276-2.4819) with Soudotape NiCrMo4

RECORD EST 259 is widely used with nickel-chromium-molybdenum alloys, which are well known for their resistance to many aggressive chemicals, in particular hydrochloric acid, sulfuric acid, and chlorides.
 Excellent weldability and wetting action, easy slag release.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	4.1
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 5.14	EN ISO 18274
ESW	Soudotape NiCrMo22	EQNiCrMo-10	B Ni 6022 (NiCr21Mo13Fe4W3)
ESW	Soudotape NiCrMo4	EQNiCrMo-4	B Ni 6276 (NiCr15Mo16Fe6W4)
ESW	Soudotape NiCrMo59	EQNiCrMo-13	B Ni 6059 (NiCr23Mo16)
ESW	Soudotape NiCrMo7	EQNiCrMo-7	B Ni 6455 (NiCr16Mo16Ti)

Packaging

Type	Weight
Metal drum	25 kg