

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

Highly basic agglomerated flux designed for Electroslag strip cladding in two thin layers of alloy 625 with Fe content less than 5% on non or low-alloyed base metal in combination with SODOTAPE 625

Designed as a productive high travel speed bi-layer weld-overlay solution allowing to reduce as much as possible the cladding overthickness.

Well adapted for strip cladding of very large vessels in combination with a 90 mm strip width.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	4.9
Grain size (EN ISO 14174)	0.25 – 1.0 mm (No. 60 – 18)
Apparent density	1.0
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 5.14	EN ISO 18274
ESW	SODOTAPE 625	EQNiCrMo-3	B Ni 6625 (NiCr22Mo9Nb)

Packaging

Type	Weight
Metal drum	25 kg