

Classifications

EN ISO 14174

ES A FB 4

Characteristics and typical fields of application

- Highly basic agglomerated flux for Electroslag strip surfacing of cobalt based alloys.
- Its specific formulation allows to reach the required full chemistry in 2 layers.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	9.1
Grain size (EN ISO 14174)	0.25 – 1.0 mm (No. 60 – 18)
Apparent density	0.9
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 5.21	EN 14700
ESW	SOU DOTAPE SCoCr21	"EQCCoCr-E"	C Co1
ESW	SOU DOTAPE SCoCr6	"EQCCoCr-A"	C Co2

Packaging

Type	Weight
Metal drum	25 kg