

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

Agglomerated Fluoride-Basic flux developed for Electroslag Strip Cladding

RECORD EST 825-1 HS is designed to produce single layer weld overlay that met requirement for nickel base Alloy 825 (N08825 - 2.4858) in combination with the SoudotaPE 825HS.

Very efficient and productive solution allowing the combination of a single layer weld overlay that can be operated at a high travel speed up to 40cm/min.

Excellent welding characteristics, easy slag release and a perfect bead aspect.

Flux properties

Polarity	DC+
Basicity index (Boniszewski)	5.1
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°C +/- 50°C

Typical strips to combine

Process	Name	ASME II C SFA 5.14	EN ISO 18274
ESW	SoudotaPE 825HS	EQNiFeCr-1	B Ni 8065 (NiFe30Cr21Mo3)

Packaging

Type	Weight
Metal drum	25 kg