

Classifications

EN ISO 14174

S A CS 3

Characteristics and typical fields of application

- Chromium alloyed agglomerated flux for Submerged Arc strip cladding of alloy 430 in two layers in combination with Soudotape 430.
- Excellent weldability and good wetting characteristics.
- Easy slag release even at high temperatures.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	1.5
Grain size (EN ISO 14174)	0.25 – 1.0 mm (No. 60 – 18)
Apparent density	1.0
Flux consumption	1.0 (kg fused flux / kg strip)
Redrying	1 to 2 hours at 350°C +/- 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
SAW	Soudotape 430	E0430	B 17	BS430

Packaging

Type	Weight
Bag	25 kg