

RECORD IN

DESCRIPTION

- Basic agglomerated flux for submerged arc welding and cladding of non-stabilised stainless steels.
- Easy slag release, good bead appearance.
- Suitable for joint welding, two-run technique and fillet welds.

GENERAL CHARACTERISTICS

- | | |
|-----------------------|----------------------------------|
| • Current / Intensity | DC (+ and -) and AC - 900 A max. |
| • Basicity index | 1.5 (according to Boniszewski) |
| • Granulometry | 0.4 - 1.4 mm (14 x 40 Mesh ASTM) |
| • Apparent density | 0.95 |
| • Consumption | 0.7 (kg fused flux / kg wire) |
| • Redrying | 1 to 2 hours at 350 +/- 50° C |

TYPICAL ANALYSIS OF WIRE AND WIRE/FLUX COMBINATION (%)

	ASME 5.9	DIN 8556	C	Mn	Si	Cr	Ni	Mo	FN
Soudor 308 L All-weld metal	ER 308 L	UP X 2 CrNi 19 9	0.015 0.020	1.60 1.30	0.40 0.85	20.0 19.9	10.0 9.8	--	-- 5
Soudor 316 L All-weld metal	ER 316 L	UP X 2 CrNiMo 19 12	0.015 0.020	1.70 1.40	0.35 0.80	18.2 18.0	12.2 11.8	2.6 2.5	-- 5

ALL-WELD METAL TYPICAL MECHANICAL PROPERTIES

Wire	Rm[MPa]	Rp0.2[MPa]	A5[%]	Av[ISO - V]	
				- 105° C	- 196° C
Soudor 308 L	580	400	38	55 J	40 J
Soudor 316 L	570	365	38	--	40 J

PACKING

25 kg (pail)

RECORD IN (following)

SUITABLE FOR

Alloy	UNS	DIN	W. - Nr.	Wires	
				Soudor 308 L	Soudor 316 L
302	S30200	X12 CrNi18 8	1.4300	x	-
304	S30400	X5 CrNi18 10	1.4301	x	-
304L	S30403	X2 CrNi18 11	1.4306	x	-
-	J92600	G - X6 CrNi18 9	1.4308	x	-
304LN	S30453	X2 CrNi18 10	1.4311	x	-
(305)	J92701	G - X10 CrNi18 8	1.4312	x	-
308	S30800	X5 CrNi18 11	1.4303	x	-
304H	S30409	X6 CrNi18 11	1.4948	x	-
321	S32100	X10 CrNiTi18 9	1.4541	x	-
347	S34700	X5 CrNiNb18 9	(1.4543)	x	-
-	S34700	X6 CrNiNb18 10	(1.4550)	x	-
316	-	G - X5 CrNiNb18 9	1.4552	x	-
316L	S31600	X5 CrNiMo17 12 2	1.4401	-	x
-	S31603	X2 CrNiMo17 13 2	1.4404	-	x
317L	J92900	G - X6 CrNiMo18 10	1.4408	-	x
317	S31703	X2 CrNiMo18 16 4	1.4435	-	x
316Ti	S31700	X5 CrNiMo17 13 3	1.4436	-	x
316Ti	S31635	X6 CrNiMoTi17 12 2	1.4571	-	x
(318)	S31635	X10 CrNiMoTi18 12	1.4573	-	x
(318)	S31640	X10 CrNiMoNb18 12	1.4583	-	x
(318)	S31640	X5 CrNiMo17 13	1.4449	-	x
(318)	S31640	G - X5 CrNiMoNb18 10	1.4581	-	x