

RECORD IND 24

DESCRIPTION

- Highly basic agglomerated flux for welding non-stabilised, stabilised, duplex and super-duplex stainless steels.
- Excellent technology and high mechanical properties.
- Low hydrogen content and very low hygroscopicity.
- Very easy slag release even in deep grooves.

APPROVALS

| Wire | C | RINA | TUV |
|-----------------|---|------|---------|
| Soudor 308 L | x | - | 4611.01 |
| Soudor 316 L | x | - | 4612.01 |
| Soudor 347 | x | - | 4613.01 |
| Soudor 318 | - | - | 5462.00 |
| Soudor 22.9.3 L | x | x | 4610.01 |

GENERAL CHARACTERISTICS

- | | |
|--------------------|----------------------------------|
| • Current | DC (+ and -) and AC - 900 A max. |
| • Basicity index | 2.3 (according to Boniszewski) |
| • Granulometry | 0.2 - 1.4 mm (14 x 60 Mesh ASTM) |
| • Apparent density | 1.0 |
| • Consumption | 0.65 (kg fused flux / kg wire) |
| • Redrying | 1 to 2 hours at 350 +/- 50° C |

PACKING

25 kg (pail)

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(following)

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

| | ASME 5.9 | DIN 8556 | C | Mn | Si | Cr | Ni | Mo | Nb | N | FN |
|------------------------------------|-------------|-----------------------|----------------|--------------|--------------|--------------|--------------|--------------|--------------|--------------|----------|
| Soudor 308 L All-weld metal | ER 308 L | UP X 2 CrNi 19 9 | 0.015 0.020 | 1.60 1.20 | 0.40 0.60 | 20.0 19.5 | 10.0 9.6 | -- -- | -- -- | -- -- | -- 5 |
| Soudor 316 L All-weld metal | ER 316 L | UP X 2 CrNiMo 19 12 | 0.015 0.020 | 1.70 1.20 | 0.35 0.60 | 18.2 18.0 | 12.2 11.6 | 2.60 2.50 | -- -- | -- -- | -- 5 |
| Soudor 347 All-weld metal | ER 347 | UP X 5 CrNiNb 19 9 | 0.030 0.030 | 1.40 1.10 | 0.45 0.60 | 19.2 18.8 | 9.6 9.3 | -- -- | 0.60 0.50 | -- -- | -- 5 |
| Soudor 318 All-weld metal | ER 318 | UP X 5 CrNiMoNb 19 12 | 0.040 0.030 | 1.25 1.00 | 0.40 0.60 | 18.5 18.1 | 11.5 11.1 | 2.50 2.45 | 0.50 0.45 | -- -- | -- 5 |
| Soudor 22.9.3 L All-weld metal | -- | UP X 2 CrNiMoN 22 9 | 0.012 0.020 | 1.70 1.20 | 0.25 0.50 | 23.0 22.0 | 9.2 9.0 | 3.00 2.80 | -- -- | 0.15 0.12 | -- 35 |
| Soudor 25.10.4 L All-weld metal | -- | UP X 2 CrNiMoN 25 10 | 0.020 0.020 | 0.50 0.40 | 0.30 0.40 | 25.0 24.0 | 9.5 9.2 | 4.00 3.90 | -- -- | 0.25 0.22 | -- 45 |
| Soudor 309 L All-weld metal | ER 309 L | UP X 2 CrNi 24 12 | 0.015 0.020 | 1.80 1.25 | 0.40 0.60 | 23.6 22.8 | 13.6 12.9 | -- -- | -- -- | -- -- | -- 10 |

ALL-WELD METAL TYPICAL MECHANICAL PROPERTIES

| Wire | Rm[MPa] | Rp0.2[MPa] | A5[%] | Av[ISO - V] | | | |
|------------------|---------|------------|-------|-------------|----------|-----------|-----------|
| | | | | + 20° C | -- 40° C | -- 105° C | -- 196° C |
| Soudor 308 L | 540 | 380 | 42 | 110 J | -- | -- | 40 J |
| Soudor 316 L | 580 | 400 | 40 | 95 J | -- | -- | 40 J |
| Soudor 347 | 610 | 420 | 38 | 100 J | -- | 60 J | 35 J |
| Soudor 318 | 600 | 430 | 38 | 100 J | -- | 80 J | 40 J |
| Soudor 22.9.3 L | 780 | 570 | 32 | 130 J | 100 J | -- | -- |
| Soudor 25.10.4 L | 850 | 650 | 28 | 100 J | 75 J | -- | -- |
| Soudor 309 L | 560 | 420 | 40 | 80 J | -- | -- | -- |