



ES Clad B

Flux for
Electroslag strip Cladding

Classification

EN 760 : SA FB 2DC

Characteristics

Agglomerated highly basic flux for electroslag strip surfacing in combination with stainless steel strip, including duplex, superduplex and fully austenitic grades.

Strip	EN ISO 14343A	Strip	EN ISO 14343A
Strip 22-11L	Z S 22 11 L	Strip 22-8-3L	S 22 9 3 N L
Strip 22-11LNb	Z S 22 11 LNb	Strip 25-22-2 L Mn	Z S 25 22 2 L Mn
Strip 24-12LNb	S 23 12 LNb	Strip 385	S 20 25 5 Cu L

Typical Flux Composition (%)

SiO ₂ + Al ₂ O ₃	CaO + MgO	CaF ₂	Basicity according to Boniszewski
20%	5%	70%	~ 4.6

Other Properties

Density kg/dm ³	Grain size Acc. to EN 760	Current - carrying capacity	Flux consumption
~ 1.0	2 - 16	1500 A, strip 60x0.5 mm	0.6 kg / kg strip electrode

Alloying Vectors

Strip	C	Si	Mn	Cr	Ni	Mo	Nb
Strip 22-11 L	0	+ 0.2	- 0.5	- 0.4	- 0.1	0	0
Strip 22-11 LNb	0	+ 0.2	- 0.5	- 0.4	- 0.1	0	- 0.1
Strip 24-12 LNb	0	+ 0.2	- 0.5		- 0.2	0	- 0.1
Strip 21-13-3L	0	+ 0.2	- 0.9		- 0.1	0.	0
Strip 385	0	+ 0.2	- 0.5	- 0.4	0	0	-

Typical Chemical Composition of a 1 layer Cladding (%)

Strip	C	Si	Mn	Cr	Ni	Mo	Nb	N
Strip 21-13-3L	0.02	0.40	1.10	18.70	12.50	2.70	-	0.04

Parameters

Strip Electrode (mm)	Polarity	Current (A)	Voltage (V)	Travel speed (cm/min)
30 x 0.5	DC +	750 - 1000	23 - 26	14 - 21
60 x 0.5	DC +	1100 - 1400	23 - 26	14 - 21
90 x 0.5	DC +	1700 - 2100	23 - 26	14 - 22

Packaging & Storage

25 kg bag or others. The flux can be stored and used upto 5 years after delivery, subject to maintain the recommended storage conditions. Flux that has picked up moisture has to be rebaked at ~ 350 °C for ~ 4hrs before use.

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