EN ISO 14174 SA CS 2B DC

Characteristics and Applications:

SL-305 is an agglomerate SAW strip cladding flux. It is suitable for 300 series stainless steel with good wet ability, smooth bead appearance & great slag detach ability. Due to SAW cladding, it could provide good merging between cladding layer & base metal. SL-305 could be applied in pressure vessel for stainless steel cladding.

Notes on usage:

1. Flux exposed to atmosphere for an excess period must be re-baked at 300-350 W for 2hr holding time.
2. Re-circulation of flux should be mixed with twice its volume of new flux prior to further use.
3. We recommend using heated hoppers for storage of flux in production.

Typical chemical composition of weld metal (wt%):

Deposi Type	Strip		Layer	C	Si	Mn	Mo	Cr	Ni	Cu	Nb
308L	TBD-309L	2	1st layer: Strip	0.02	0.38	1.63	0.05	23.31	13.03	0.036	--
	TBD-308L		2nd layer: Strip	0.01	0.34	1.63	0.02	20.33	10.25	0.029	--
			2nd layer: Weld metal	0.03	0.95	0.77	0.02	18.99	10.24	0.029	--
316L	TBD-309L	2	1st layer: Strip	0.02	0.38	1.63	0.05	23.31	13.03	0.036	--
	TBD-316L		2nd layer: Strip	0.02	0.31	1.75	2.57	18.67	12.81	0.021	--
			2nd layer: Weld metal	0.03	0.90	0.88	1.97	17.80	11.90	0.051	--
347	TBD-309L	2	1st layer: Strip	0.02	0.38	1.63	0.05	23.31	13.03	0.036	--
	TBD-347		2nd layer: Strip	0.01	0.38	1.78	0.07	19.73	10.26	0.048	0.47
			2nd layer: Weld metal	0.03	0.94	0.90	0.06	19.03	10.37	0.042	0.29

Remark:

1. Typical welding parameter úStrip : 0.5X60mm, DC+/750A/28V/12cpm/ESO: 35mm/Flux Covered: 40mm Interpass temperature <150 š
2. The chemistry will be influenced by welding parameter õwelding equipment and bead thickness etc.

Size of strip:

Width & Thickness: 30 x 0,5mm, 60 x 0,5mm, 90 x 0,5mm