

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

Agglomerated Fluoride-Basic flux developed for Electroslag Strip Cladding.

RECORD ES 2209-1 is designed to produce weldoverlay that met requirement for 2209 duplex stainless steel with SOUDOTAPE 22.6.3L strip electrode in single layer.

Excellent pitting corrosion resistance PREN>35

Excellent weldability and good wetting characteristics.

Easy slag removal even at high temperatures.

Best choice for strip electrode saving.

Flux properties

Polarity	DC+
Basicity index (Boniszewski)	3.8
Grain size (EN ISO 14174)	0.25 – 1.0 mm (No. 60 – 18)
Apparent density	1.0
Flux consumption	0.8 (kg fused flux / kg strip)
Redrying	1 to 2 hours at 350°C +/- 50°C

Typical strips to combine

Process	Name	ASME II C SFA 5.9	EN ISO 14343-A	EN ISO 14343-B
ESW	SOUDOTAPE 22.6.3L	(EQ2209)	B Z 22 6 3 N L	BS(2209)