

Classifications

ASME II C SFA 5.14

EN ISO 18274

EQNiFeCr-1

B Ni 8065 (NiFe30Cr21Mo3)

Characteristics and typical fields of application

- SOUDOTAPE 825HS is a Nickel base strip developed for Electroslag Strip Cladding of Alloy 825 (UNS N08825 - 2.4858) single layer in combination with flux RECORD EST 825-1 HS
- SOUDOTAPE 825HS is also usable in combination with flux RECORD EST 825H HS in two thin layers or single layer when Nickel content above 38% is requested.

Typical analysis

	C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Cu
wt.-%	0.01	0.3	0.8	22.2	42.3	3.0	0.7	Rem.	2.0

Typical fluxes to combine

Process	Name	EN ISO 14174
ESW	RECORD EST 138	ES A FB 2B
ESW	RECORD EST 201	ES A FB 2B
ESW	RECORD EST 320	ES A FB 2B
ESW	RECORD EST 825-1 HS	ES A FB 2B
ESW	RECORD EST 825H HS	ES A FB 2B

Packaging

Size(s) in mm	Type	Weight
30 x 0,5	Coil	25 - 30 kg
60 x 0,5	Coil	50 - 60 kg
90 x 0,5	Coil	75 - 90 kg

Other sizes and coil weights on request.