

## Classifications

EN ISO 14174

S A CS 2B

## Characteristics and typical fields of application

**RECORD INT 110** is a specialized fluoride basic flux meticulously designed for Submerged Arc strip cladding. It is ideal for creating weld overlays that meet the rigorous standards of 2205 duplex stainless steel, utilizing the cost-effective SoudoTAPE 22.6.3L strip electrode in a three-layer application

**Exceptional Corrosion Resistance:** Delivers outstanding pitting corrosion resistance with a Pitting Resistance Equivalent Number (PREN) greater than 35.

**Superior Weldability:** Offers excellent wetting characteristics and smooth overlapping behavior between adjacent beads.

**Easy Slag Removal:** Ensures effortless slag removal even at elevated interpass temperatures.

**Reduced Weld Defects:** Minimizes the risk of hot cracking and other weld defects.

**Enhanced Corrosion Resistance:** Provides superior resistance to stress corrosion cracking, pitting, and crevice corrosion, particularly in chloride-rich environments.

**RECORD INT 110** is suitable for a diverse range of environments and applications, including oil and gas, chemical processing, marine engineering, and construction, making it an ideal choice for demanding applications.

**RECORD INT 110**, when used with duplex stainless steels, ensures the production of high-quality, reliable welds. Its advanced formulation meets the demands of challenging applications, providing exceptional performance and longevity.

Choose **RECORD INT 110** for your next project to achieve unmatched weld quality and corrosion resistance in the most demanding environments.

## Flux properties

Polarity	DC +
Basicity index (Boniszewski)	1.2
Grain size (EN ISO 14174)	0.40 – 1.4 mm (No. 40 – 14)
Apparent density	1.0
Flux consumption	1.0 ( kg fused flux / kg strip )
Redrying	1 to 2 hours at 350 +/- 50°C

## Typical strips to combine

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

## Packaging

Type	Weight
Metal drum	25 kg