

## Classifications

EN ISO 14174

S A CS 3

## Characteristics and typical fields of application

Agglomerated Calcium-Silicate flux for hard-facing with Mo additions.

RECORD SMO TW is designed to produce multiple layer cladding that met requirement for 0.5%Mo (1.5415 - 16Mo3 - SA387 Gr. 1) steel designation.

In combination with strip electrode SOUDOTAPE A and solid wire Union S1, deposit can reach hardness in the range of 150HB. Service temperatures up to 500°C.

## Flux properties

Polarity	DC +
Basicity index (Boniszewski)	1.1
Grain size (EN ISO 14174)	0.40 – 1.4 mm (No. 40 – 14)
Apparent density	0.9
Flux consumption	1.0 ( kg fused flux / kg strip )
Redrying	1 to 2 hours at 350 +/- 50°C
Moisture content (AWS A4.4M: 2001; 1050 °C)	<0.2

## Typical strips to combine

Process	Name	AWS A5.17 / SFA-5.17	EN ISO 14171-A	EN ISO 14171-B
SAW	SOUDOTAPE A	(EL8)	(S1)	(SU08)
SAW	Union S 1	EL12	S1	

## Packaging

Type	Weight
Bag	25 kg