

ASME II C SFA 5.9 :	EQ 430
EN 14343-1 :	B 17
DIN 8556 :	UP X8Cr18
W-Nr. :	1.4015

DESCRIPTION

- Ferritic 17%Cr strip designed for multi-layers cladding of the 410 family alloys.
- SOUDOTAPE 430 can be used in combination with RECORD RT 152 and RT 162 (submerged arc strip cladding) or with RECORD EST 452 (electroslag strip cladding) to obtain alloy 410 NiMo.
- To obtain a 410 NiMoNbV alloy, SOUDOTAPE 430 is to be used in combination with Record RT 742 (submerged arc strip cladding).

SUITABLE FOR

- Continuous casting rolls, milling rolls, hardfacing applications in steelworks,...

TYPICAL STRIP ANALYSIS

Strip designation	C	Mn	Si	Cr	Ni	Mo	N
SOUDOTAPE 430	0.045	0.4	0.3	16.2	0.1	0.02	0.038

TYPICAL WELD METAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Submerged arc strip cladding with RECORD RT 152 / RT 742 on a 0.2% C - Steel

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	Nb	Thickn. (mm)	Hardness
3 rd Layer (13Cr4Ni1Mo)	RT 152	0.033	0.5	0.9	14.0	3.8	0.9	-	3.5	385 HB
2 nd Layer (1 st layer with RT 162) (13Cr4Ni1Mo)	RT 162	0.039	0.5	1.1	16.2	5.3	0.9	-	3.0	35HRc
3 rd Layer (13Cr3Ni1MoNbV)	RT 742	0.1	0.3	0.9	13.1	4.0	1.6	0.2	3.0	40 HRc

- Electroslag strip cladding with RECORD EST 452 on a 0.2% C - Steel

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	Thickn. (mm)	Hardness
3 rd Layer (13Cr4Ni1Mo)	EST 452	0.045	0.3	0.4	14.8	3.6	0.5	3.5	40 HRc

AVAILABLE STRIP SIZES

- Standard : 30 x 0.5 mm, 60 x 0.5 mm or 90 x 0,5 mm.
- Other sizes on request.

PACKING

- 30 x 0.5 mm : 25 kg to 30 kg.
- 60 x 0.5 mm : 50 kg to 60 kg.
- 90 x 0.5 mm : 70 kg to 90 kg.

- Other sizes on request.

Note : For additional information about cladding conditions and deposited weld metal properties, please refer to the corresponding flux technical data sheet, cladding data sheet or contact us.