

AST 100A

SAW Fluxes Cladding

AST 100A is an agglomerated submerged-arc welding flux used in combination with ferritic stainless steel Suprastrip 430. The special formula enhances the weld bead profile with excellent and easy slag detachability and compensates the slight chromium burn out during welding .
The flux is suitable for the hard facing weld overlay of continuous casting rolls.
Damp flux should be re-dried at 300-350°C. Grain size according to EN 760: 2-20.

Wire	Classification
	DIN 32522 : BC S 4 845 DC+ 12 B-3-16

Wire	Approvals	Grades
------	-----------	--------

Flux Analysis	
Al ₂ O ₃	15 %
SiO ₂	32 %
CaF ₂	10 %
MgO	28 %

Basicity to Boniszewski 1

Analysis of all-weld metal (Typical values in %)

Wire	C	Mn	Si	Cr	Ni	Mo	Nb	N	Cu
SUPRASTRIP 430 3rd Layer	0.05	0.25	0.90	16.05	-	-	-	-	-

All-weld metal Mechanical Properties

Wire	Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Hardness
SUPRASTRIP 430	-	-	-	-	220HB

Packaging data

Metallic drum 30kg

Further forms of delivery on request.

Current condition

DC+