

# AST 300

## SAW Fluxes Cladding

AST 300 is used with austenitic stainless strips (308L, 309L, 309LMo, 316L, etc). The AST 300 flux composition compensates for chromium and nickel loss during welding and enhances the weld bead profile, slag residues are self releasing.

AST 300 is used for submerged arc strip cladding of pressure vessels, chemical and petrochemical reactor vessels. Damp flux should be re-dried at 300-350°C. Grain size according to EN 760: 2-20.

Wire	Classification
	DIN 32522: BCS 5 83255 DC+ 13 B-3

Wire	Approvals	Grades
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### Flux Analysis

Basicity to Boniszewski 1

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

Wire	C	Mn	Si	Cr	Ni	Mo	Nb	N	Cu
SUPRASTRIP 308L 2nd Layer	0.014	1.40	0.90	19	10.70	-	-	-	-
SUPRASTRIP 309L 1st Layer	0.02	0.90	0.70	17.30	10.40	-	-	-	-

### Packaging data

Metallic drum 30kg

Further forms of delivery on request.

### Current condition

DC+