

AST 300 is used with austenitic stainless strips such as SUPRASTRIP 19 9 L, 24 13 L, 21 13 3 L, 19 12 3 L. 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 and is also suitable to be combined with stainless steel wires (OE-308L, OE-316L, OE-309L). Damp flux should be re-dried at 300-350°C. Grain size according to EN 760: 2-20.

### Classification

EN ISO 14174: S A CS 2

### Flux Main Components

SiO <sub>2</sub>	29 %
MgO	25 %
Al <sub>2</sub> O <sub>3</sub>	16 %
CaF <sub>2</sub>	10 %

**Boniszewski Basicity** 1.1

### Chemical analysis (Typical values in %)

		<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Cr</b>	<b>Ni</b>
All weld metal	SUPRASTRIP 19 9 L	0.028	1.42	0.78	19.6	10.4
All weld metal	SUPRASTRIP 24 13 L	0.059	1.46	0.65	17.7	10.1

### Redrying

300-350°Cx2-4h

### Current Conditions

DC+