

ELT 600S is a high basic, high speed welding flux (35 cm/min) used in combination with high nickel alloyed strip, such as Suprastrip 625, for the cladding of surfaces according to the electroslag process. ELT 600S is used, due to its very high hot cracking resistance, for the electroslag cladding of pressure vessels, chemical and petrochemical reactor vessels. ELT 600S has excellent welding characteristics with the weld bead exhibiting good wetting at the weld toes

ELT 600S exhibits a very low moisture pick up.

The special formula enhances a smooth weld seam surface with excellent and easy slag detachability.

Damp flux should be re-dried at 300-350°C.

Grain size according to EN 760: 2-20.

Classification

EN ISO 14174: S A FB 2

Flux Main Components

CaF ₂	65 %
Al ₂ O ₃	20 %
SiO ₂ + TiO ₂	12 %

Boniszewski Basicity 4

Chemical analysis (Typical values in %)

		C	Mn	Si	Cr	Ni	Mo	Nb	Fe
All weld metal	SUPRASTRIP 625	0.04	0.19	0.25	18.2	Rem	7.4	2.8	15

Redrying

Re-dry at 300-350°C for 2 hours

Current Conditions

DC+