AST 600

TOP FEATURES

- Used for submerged arc strip cladding
- The weld bead shows a very hot cracking resistance
- Slag residues are self releasing

TYPICAL APPLICATIONS

- Pressure vessels
- Chemical and petrochemical reactor vessels

CLASSIFICATION

Flux	EN ISO 14174 : S A AB 2

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

Strip grade	C	Mn	Si	Ni	Cr	Mo	Nb	Fe
SUPRASTRIP/CLADSTRIP 625 - 1st layer	0.04	1.0	0.4	Rem	19.0	8.0	2.8	12.0
SUPRASTRIP/CLADSTRIP 625 - 2nd layer	0.02	1.0	0.3	Rem	20.0	9.0	3.2	3.0

FLUX CHARACTERISTICS

Current type	DC+
Basicity (Boniszewski)	1.5
Grain size (EN ISO 14174)	2-20
Redrying	300-350°C x min. 2h

PACKAGING AND AVAILABLE SIZES

Packaging	Weight (kg)	Item number
DRY BAG	25.0	W000280081

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.