

Classifications

EN ISO 14174

ES A FB 2B

Characteristics and typical fields of application

Experience unmatched efficiency and quality with the **RECORD ES 120 HR**, a high-performance, agglomerated fluoride-basic flux specifically engineered for Electroslag Strip Cladding. This flux is the ultimate solution for achieving superior weld overlay in the restoration of 825 nickel alloy clad plates.

Why Choose RECORD ES 120 HR ?

Achieve up to 20% higher productivity compared to conventional cladding solutions. With cladding speeds reaching up to 260 mm/min, RECORD ES 120 HR ensures fast and efficient operations, significantly reducing project timelines.

When paired with **SOUDOTAPE 625**, the single-layer deposit creates an over-alloyed 825 nickel alloy with an iron content maintained below 10%. This ensures high-quality, corrosion-resistant cladding, perfect for demanding applications.

Reduce strip electrode consumption by up to 15%, making RECORD ES 120 HR the most cost-effective choice for 825 alloy clad plate restoration. Lower material use without compromising on quality or performance.

Enjoy excellent weld properties, including easy slag release and a smooth, shiny overlay surface. The flawless finish and high integrity of the weld make it the best solution for single-layer restoration of 825 clad pipes.

RECORD ES 120 HR is not just a product, it is a revolution in the world of weld overlay. Choose RECORD ES 120 HR for unparalleled efficiency, quality, and economy in next clad restoration project.

Flux properties

Polarity	DC +
Basicity index (Boniszewski)	5.0
Grain size (EN ISO 14174)	0.25 – 1.0 mm (No. 60 – 18)
Apparent density	1.0
Flux consumption	0.7 (kg fused flux / kg strip)
Redrying	1 to 2 hours at 350 +/- 50°C

Typical strips to combine

Process	Name	ASME II C SFA 5.14	EN ISO 18274
ESW	SOUDOTAPE 625	EQNiCrMo-3	B Ni 6625 (NiCr22Mo9Nb)