



# CEWELD FL 838

TYPE	Agglomerated flux for SAW welding stainless steels and Nickel based alloys.
ANWENDUNGEN	Vessels, tanks, boilers, steam turbines, shafts, valves, cladding steel rollers with stainless steel and Nickel based alloys
EIGENSCHAFTEN	FL 838 is an agglomerated flux for SAW welding stainless steels and Nickel based alloys: AISI 308L, 347, 316L, 309L and 309LN. Basicity: About 1,9 (according to Boniszewski) Current: DC or AC, in single or multi-wires Grain size: 2-1
KLASSIFIKATION	EN ISO                    14174: SA AF 2 5644 DC H5

GEEIGNET FÜR	<p><b>Typical wire combinations</b></p> <p><b>CEWELD®SA 307</b> ISO 14343-A: ~S 18 8 Mn AWS 5.9: ER307</p> <p><b>CEWELD®SA 308L</b> ISO 14343-A: ~S 19 9 L AWS 5.9: ER308L</p> <p><b>CEWELD®SA 309L</b> ISO 14343-A: ~S 23 12 L AWS 5.9: ER309L</p> <p><b>CEWELD®SA 309LMo</b> ISO 14343-A: ~S 23 12 3 L AWS 5.9: ~ER309LMo</p> <p><b>CEWELD®SA 310</b> ISO 14343-A: S 25 20 AWS 5.9: ER310</p> <p><b>CEWELD®SA 316L</b> ISO 14343-A: S 19 12 3 L AWS 5.9: ER316L</p> <p><b>CEWELD®SA 317L</b> ISO 14343-A: S 18 15 3 L AWS 5.9: ER317L</p> <p><b>CEWELD®SA 318</b> ISO 14343-A: S 12 12 3 Nb AWS 5.9: ER318</p> <p><b>CEWELD®SA 347</b> ISO 14343-A: S 19 9 Nb AWS 5.9: ER347</p> <p><b>CEWELD®SA 2209</b> ISO 14343-A: S 22 9 3 N L AWS 5.9: ER2209</p> <p><b>CEWELD®SA 904L</b> ISO 14343-A: S 20 25 5Cu L AWS 5.9: ER385</p> <p><b>CEWELD®SA 2594</b> ISO 14343-A: 25 9 4 N L AWS 5.9: ER2594</p> <p><b>Hardfacing:</b></p> <p><b>CEWELD®SA 410NiMo</b> ISO 14343-A: S 13 4 AWS 5.9: ER410NiMo    Hardness: HRc ~380 after PWHT HB ~250</p> <p><b>CEWELD®SA 420B</b> ISO 14343-B: 420 AWS 5.9: ER420                    Hardness: HRc ~ 50</p> <p><b>CEWELD®SA 430</b> ISO 14343-A: S 17 AWS 5.9: ER430                    Hardness: HB~ 250</p>
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ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPISCHE CHEMISCHE ZUSAMMENSETZUNG NACH GEWICHT (%)

CaF2	Al2O3+CaO+MgO	Al2O3	S	P
14	60	24	0.037	0.013

MECHANISCHE GÜTEWERTE

RÜCKTROCKNUNG                    Not required

GAS ACC. EN ISO 14175



# CEWELD FL 838

FL 838 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	25	8720663404091