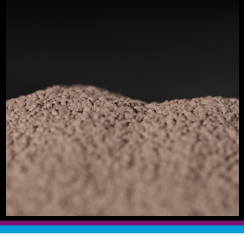


CEWELD FL 880

certilas® THE FILLER METAL SPECIALIST

TYPE

Fused flux for SAW welding stainless steels and Nickel based alloys.

APPLICATIONS

CEWELD® FL 880 is also suitable for **welding both low alloy steels** for use at elevated temperatures and in combination with austenitic stainless steels.
It is suitable **for joint welding and surfacing** of:
creep resistant CrMo steels for boiler, vessel and pipe fabrication
Martensitic and ferritic Cr(NiMo) steels with the appropriate wire electrodes and heat treatments
Austenitic CrNi(Mo) steels (including ELC grades) resistant to intergranular corrosion in both as-welded and solution treated condition
High alloy CrNi(Mo) steels for low temperature service and heat resistant steels
High-alloy Cr(NiMo) steels in combination with low-alloy steels (dissimilar joints)
Nickel base alloys using NiCr and NiCrMo wire electrodes.

PROPERTIES

CEWELD® FL 880 is a **specially designed glassy fused** welding flux for austenitic stainless steels. As a result of the **semi-basic flux** characteristics, **crack free** welds can be achieved on most stainless steel grades when welded with the appropriate wire electrodes. The metallurgical behaviour of the flux is neutral (**C neutral, low Si pick-up and low Mn burn-out**) without Cr compensation.
It is suitable for DC single or DC/AC multi-wire welding and produces smooth, slag free weld beads with flat weld interfaces even in narrow gaps and on preheated workpieces.
Basicity according to Boniszewski: ~1,3
Flux density: 1.5 kg / dm3 (l)
Grain size acc. to ISO 14174: 1 – 16
Current-carrying capacity: up to **900 A DC** using one wire or **DC/AC multi-wire**

CLASSIFICATION

EN ISO 14174: SF CS 2 5742 DC

SUITABLE FOR

S355, S420, S460, S690, P500, P550, X65, X70, X80, Weldox 700, Naxtra 70, Hardox 400, Dilimax, P91, P24

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)

Al2O3	CaF2	SiO2	CaO+MgO
5	20	30	35

MECHANICAL PROPERTIES

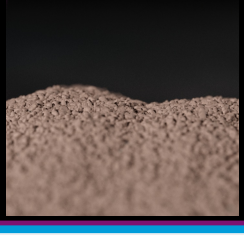
REDRYING

Not required

WIRE & FLUX COMBINATION

Typical wire combinations: CEWELD® S2Mo ISO 14171-A: S 46 2 AR S2Mo AWS 5.17_5.23: EA2 CEWELD® S2CrMo1 ISO 24598-A: S CrMo1 AWS 5.17_5.23: EB2(R) CEWELD® S2CrMo2 24598-A: S Z CrMo2Mn AWS 5.17_5.23:EB3 CEWELD® S2CrMo5 ISO 24598-A: S CrMo5 AWS 5.17_5.23: EB6 CEWELD® SA 80S-B8 ISO 24598-A: S CrMo9 AWS 5.17_5.23: EB8 CEWELD® SA 90S-B9 ISO 24598-A: S CrMo91 AR AWS 5.17_5.23: EB91 CEWELD®SA 307 ISO 14343-A: ~S 18 8 Mn AWS 5.9: ER307 CEWELD®SA 308L ISO 14343-A: ~S 19 9 L AWS 5.9: ER308L CEWELD®SA 309L ISO 14343-A: ~S 23 12 L AWS 5.9: ER309L CEWELD®SA 309LMo ISO 14343-A: ~S 23 12 3 L AWS 5.9: ~ER309LMo CEWELD®SA 310 ISO 14343-A: S 25 20 AWS 5.9: ER310 CEWELD®SA 316L ISO 14343-A: S 19 12 3 L AWS 5.9: ER316L CEWELD®SA 317L ISO 14343-A: S 18 15 3 L AWS 5.9: ER317L CEWELD®SA 318 ISO 14343-A: S 12 12 3 Nb AWS 5.9: ER318 CEWELD®SA 347 ISO 14343-A: S 19 9 Nb AWS 5.9: ER347 CEWELD®SA 2209 ISO 14343-A: S 22 9 3 N L AWS 5.9: ER2209 CEWELD®SA 904L ISO 14343-A: S 20 25 5Cu L AWS 5.9: ER385 CEWELD®SA 2594 ISO 14343-A: 25 9 4 N L AWS 5.9: ER2594 CEWELD®SA Nicro 600 ISO 18274-A: S Ni 6082 (NiCr20Mn3Nb) AWS 5.14: ERNiCr-3 CEWELD®SA Nicro 625 ISO 18274-A: S Ni 6625 (NiCr22Mo9Nb) AWS 5.14: ERNiCrMo-3 CEWELD®SA Alloy 825 ISO 18274-A: S Ni8065 (NiFe30Cr21Mo3) AWS 5.14: ERNiFeCr-1 CEWELD®SA Alloy C-276 ISO 18274-A: S Ni 6276 (NiCr15Mo16Fe6W4) AWS 5.14: ERNiCrMo-4

GAS ACC. EN ISO 14175



CEWELD FL 880

FL 880 0,1 - 1,6MM

Packaging	KG/unit	EanCode
Bag	15/25	8720663404114

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