



# CEWELD FL 838

**TYPE** Agglomerated flux for SAW welding stainless steels and Nickel based alloys.

**APPLICATIONS** CEWELD® FL 838 is designed for joint welding and surfacing. It is specifically designed for welding austenitic and austenitic-ferritic (duplex/superduplex) stainless steels (DSS) such as Grade 2205 (Duplex S31805/S32205 = 1.4462) or Grade 2507 (Superduplex S32750 = 1.4410).  
**Austenitic CrNi(Mo) steels** (including Nb/Ti and 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  
**Nickel base alloys** using NiCr and NiCrMo wire electrodes to AWS A5.14 / EN ISO 18274  
**Welding of dissimilar metals** such as low alloy steels to stainless steels or special cryogenic steels (e.g. 9%Nisteel) in flat or 2G position.

**PROPERTIES** CEWELD® FL 838 is an **agglomerated aluminate-fluoride-basic Flux**. This basic but **neutral flux** gives excellent results on standard austenitic and heat resistant stainless steels when used with the appropriate wire electrodes according to EN ISO 14343 or ASME II C: SFA 5.9. It is also suitable for joint and overlay welding of nickel alloys when used with appropriate Ni-base wire electrodes.  
**Basicity according to Boniszewski:** ~1,9  
**Flux density:** 1.0 kg / dm<sup>3</sup> (l)  
**Grain size acc. to ISO 14174:** 2 – 16  
**Current-carrying capacity:** up to 900 A DC using one wire

**CLASSIFICATION** EN ISO 14174: SA AF 2 5644 DC H5

**SUITABLE FOR** **Typical wire combinations**  
**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  
**Hardfacing:**  
**CEWELD®SA 410NiMo** ISO 14343-A: S 13 4 AWS 5.9: ER410NiMo Hardness: HRc ~380 after PWHT  
 HB ~250  
**CEWELD®SA 420B** ISO 14343-B: 420 AWS 5.9: ER420 Hardness: HRc ~ 50  
**CEWELD®SA 430** ISO 14343-A: S 17 AWS 5.9: ER430 Hardness: HB~ 250

**APPROVALS**

**WELDING POSITIONS**



TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)	CaF2	Al2O3+CaO+MgO	Al2O3	S	P
	14	60	24	0.037	0.013

**MECHANICAL PROPERTIES**

**REDRYING** Not required

**GAS ACC.** EN ISO 14175



# CEWELD FL 838

FL 838 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	25	8720663404091