CEWELD FL 180

certilas® THE FILLER METAL SPECIALIST

TYPE

Agglomerated aluminate rutile welding flux with pick up of Mn and Si, suitable for welding carbon steel.

APPLICATIONS

CEWELD® FL 180 is **preferably used for single pass,** two run and fillet SAW welding. It is designed for all SAW processes and for welding common carbon-manganese, low-alloy structural and boiler steels with yield strengths **up to 355 MPa (t < 25 mm)**. The flux is suitable for **high speed welding (up to 2 m/min.)** and gives very good weld bead appearance and excellent slag release even on small angle preparation and fillet welds.
Main applications include structural steelwork, thin walled containers, LPG cylinders and **finned tube** walls.

PROPERTIES

CEWELD® FL 180 is an **agglomerated aluminate rutile** welding flux. Its chemical nature provides **high resistance to cracking** in single pass applications. Other features include resistance to porosity when **welding rusty sheets,** heavy scale or other sheet surface contaminants (e.g. special primer coatings) and low sensitivity to arc blow.
Basicity according to Boniszewski: ~0,6
Flux density: 1.0 kg / dm3 (l)
Grain size acc. to ISO 14174: 2 - 16; 2 – 12; 2 - 20
Current-carrying capacity: up to **800 A (DC or AC)** using one wire

CLASSIFICATION

EN ISO 14174: SA AR 1 76 AC H5

SUITABLE FOR

Typical wire combinations:
CEWELD® S1 ISO 14171-A: S 38 A AR S1 AWS 5.17_5.23: F48A0-EL12 F7AZ-EL12
CEWELD® S2 ISO 14171-A: S 42 0 AR S2 AWS 5.17_5.23: F48A0-EM12(K) F7AZ-EM12(K)
CEWELD® S2Si ISO 14171-A: S 42 2 AR S2Si AWS 5.17_5.23: F48A2-EM12K F7A0-EM12K
CEWELD® S2Mo ISO 14171-A: S 46 2 AR S2Mo AWS 5.17_5.23: F55A2-EA2-A2 F8A0-EA2-A2
CEWELD® S2CrMo1 ISO 24598-A: S S CrMo1 AR AWS 5.17_5.23: F55PZ-EB2-B2 F8PZ-EB2-B2

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)

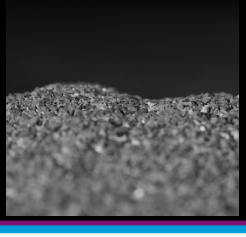
S	P	Al2O3+TiO2
0.017	0.028	45.1

MECHANICAL PROPERTIES

REDRYING

350°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD FL 180

FL 180 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	27,5	8720663403964

FL 180 0,2 - 2,0MM

Packaging	KG/unit	EanCode
Bag	25	8720663403971