



# CEWELD FL 838

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

**TOEPASSINGEN** Vessels, tanks, boilers, steam turbines, shafts, valves, cladding steel rollers with stainless steel and Nickel based alloys

**EIGENSCHAPPEN** 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

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

**GESCHIKT VOOR**

**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

**GOEDKEURINGEN**

**LASPOSITIES**



**TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)**

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

**MECHANISCHE WAARDEN**

**HERDROGEN** Not required

**GAS ACC. EN ISO 14175**



# CEWELD FL 838

FL 838 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	25	8720663404091