



# CEWELD FL 860 ESHC

|                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                           |         |
|-----------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|---------|
| TYPE                                                | High basic agglomerated flux for welding Nickel based strips with the elctro slag process.                                                                                                                                                                                                                                                                                                                                                                                            |                           |         |
| ANWENDUNGEN                                         | Designed for ES strip cladding in offshore, apparatus, vessel, boilers and chemical industry.                                                                                                                                                                                                                                                                                                                                                                                         |                           |         |
| EIGENSCHAFTEN                                       | FL 860 ESHC is a highly basic flux for Nickel based strip electro slag cladding. Basicity: about 4,2 (according to Boniszewski) Current: DC + Grain size: 2-16                                                                                                                                                                                                                                                                                                                        |                           |         |
| KLASSIFIKATION                                      | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 14174: ES A FB 2B 5644 DC |         |
| GEEIGNET FÜR                                        | <b>Typical strip combinations:</b><br><b>CEWELD SA Nicro 600 strip</b> ISO 18274: S Ni 6082 (NiCr20Mn3Nb) AWS 5.14: EQNiCr-3 (UNS N06082)<br><b>CEWELD SA Nicro 602 CA (6025HT) strip</b> ISO 18274: S Ni6025 (NiCr25Fe10AlY) AWS 5.14: EQNiCrFe-12 (UNS N06025)<br><b>CEWELD SA Nicro 625 strip</b> ISO 18274: S Ni 6625(NiCr22Mo9Nb) AWS 5.14: EQNiCrMo-3 (UNS N06625)<br><b>CEWELD SA Alloy 825 strip</b> ISO 18274: S Ni 8065(NiFe30Cr21Mo3Cu3) AWS 5.14: EQNiFeCr-1 (UNS N08065) |                           |         |
| ZULASSUNGEN                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                           |         |
| SCHWEISSPOSITIONEN                                  |                                                                                                                                                                                                                                                                                                                                                                                                      |                           |         |
| TYPISCHE CHEMISCHE ZUSAMMENSETZUNG NACH GEWICHT (%) | CaF2                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | SiO2                      | CaO+MgO |
|                                                     | 70                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 20                        | 5       |
| MECHANISCHE GÜTEWERTE                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                           |         |
| RÜCKTROCKNUNG                                       | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                           |         |
| GAS ACC. EN ISO 14175                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                           |         |



# CEWELD FL 860 ESHC

FL 860 ESHC 0,2 - 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Bag       | 25      | 8720663404213 |