



CEWELD FL 838

TYPE	Agglomerated flux for SAW welding stainless steels and Nickel based alloys.		
ANWENDUNGEN	Vessels, tanks, boilers, steam turbines, shafts, valves, cladding steel rollers with stainless steel and Nickel based alloys		
EIGENSCHAFTEN	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		
KLASSIFIKATION	EN ISO	14174: SA AF 2 5644 DC H5	

GEEIGNET FÜR	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

ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPISCHE CHEMISCHE ZUSAMMENSETZUNG NACH GEWICHT (%)

CaF ₂	CaO+MgO	SiO ₂ +TiO ₂	Al ₂ O ₃ +MnO
50	5	10	35

MECHANISCHE GÜTEWERTE

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175



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FL 838 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	25	8720663404091