



# CEWELD FL 860 ESHC

TYPE	High basic agglomerated flux for welding Nickel based strips with the electro slag process.		
APPLICATIONS	<p>CEWELD® FL 860 ESH is designed for <b>overlay welding and cladding of joints with typical NiCr(Mo) strip electrodes</b> of Alloy 600®, Alloy 625® and other NiCrMo alloys. It can be used for the various ElectroSlag (ES) processes, with or without magnetic control, as well as for cladding processes that achieve higher deposition rates by means of ES high-speed welding or by using the ESO® (Extended Stick Out) cladding system with the benefit of the I<sup>2</sup>R effect.</p> <p>Can be used for <b>joint cladding and surfacing</b> of chemical plant components and nuclear/offshore equipment to achieve high NiCr(Mo) overlays such as <b>Alloy 600®, Alloy 625® and similar alloys (Alloy 59®, C276®)</b>. Depending on the specification and in combination with suitable strip electrodes according to ASME II C SFA-5.14 or EN ISO 18274, constant weld overlays with low dilution rates can be achieved in single or multiple layers.</p>		
PROPERTIES	<p>CEWELD® FL 860 ESH is a <b>high fluoride basic, agglomerated neutral flux</b> (without alloy compensation). It provides <b>excellent slag removal</b> without slag residue - in the first layer on preheated substrates as well as in subsequent layers or when joint cladding. <b>Smooth weld beads</b> and notch-free transitions are other features when appropriate process parameters are applied. Low and constant dilution rates are observed.</p> <p>The flux has a low hydrogen potential which makes it ideal for overlay welding of heat resistant substrates such as A387 types.</p> <p>CEWELD® FL 860 ESH shows constant chemical reactions typical of an unalloyed flux.</p> <p><b>Basicity according to Boniszewski:</b> ~4,6</p> <p><b>Flux density:</b> 1.1 kg / dm<sup>3</sup> (l)</p> <p><b>Grain size acc. to ISO 14174:</b> 2 – 16</p> <p><b>Current-carrying capacity:</b> up to <b>1.500 A DC</b> using one strip electrode 60 x 0.5 mm</p>		
CLASSIFICATION	EN ISO	14174: ES A FB 2B 5644 DC	
SUITABLE FOR	<p><b>Typical strip combinations:</b></p> <p><b>CEWELD SA Nicro 600 strip ISO 18274: S Ni 6082 (NiCr20Mn3Nb) AWS 5.14: EQNiCr-3 (UNS N06082)</b></p> <p><b>CEWELD SA Nicro 602 CA (6025HT) strip ISO 18274: S Ni6025 (NiCr25Fe10AlY) AWS 5.14: EQNiCrFe-12 (UNS N06025)</b></p> <p><b>CEWELD SA Nicro 625 strip ISO 18274: S Ni 6625(NiCr22Mo9Nb) AWS 5.14: EQNiCrMo-3 (UNS N06625)</b></p> <p><b>CEWELD SA Alloy 825 strip ISO 18274: S Ni 8065(NiFe30Cr21Mo3Cu3) AWS 5.14: EQNiFeCr-1 (UNS N08065)</b></p>		
APPROVALS			
WELDING POSITIONS	 PA    PB    PC		
TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)	CaF <sub>2</sub>	SiO <sub>2</sub>	CaO+MgO
	70	20	5
MECHANICAL PROPERTIES			
REDRYING	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