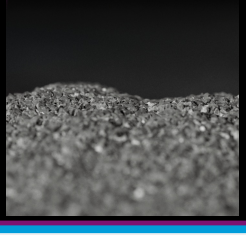


CEWELD FL 830 ESH

certilas® THE FILLER METAL SPECIALIST

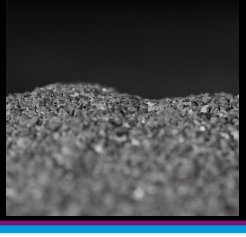
TYPE	High basic, agglomerated and neurtral flux for overlay welding stainless steel strip electro slag welding
TOEPASSINGEN	CEWELD® FL 830 ESH is designed for **overlay welding and joint cladding in combination with stainless steel strip** electrodes of the Cr, CrNi(Mo) types. It is suitable for the ES process and especially for use with the ESO® (Extended Stick Out) cladding system, which provides the highest possible deposition rates due to the Joule heat (I2R effect). It can be used for joint cladding and surfacing of chemical plant components and equipment in the nuclear/offshore fields to produce corrosion resistant deposits in 1 or more layers. When used in combination with suitable EQ300/EQ400 series strip electrodes to A5.9 or EN ISO 14343 (EN 12072), constant weld surfacing can be achieved with low dilution rates
EIGENSCHAPPEN	CEWELD® FL 830 ESH is a **high fluoride basic, agglomerated and neutral flux** (no alloy compensation). CEWELD® FL 830 ESH, **especially in combination with Nb-alloyed strips** , gives excellent slag removal without slag residue in the first layer on preheated substrates as well as in subsequent layers. The flux has a low hydrogen potential making it ideal for overlay welding of heat resistant steels such as A387 types. Smooth weld beads and notch free transitions are achievable in all cladding processes. Low but constant dilution rates can be achieved by using process characteristic welding parameters. CEWELD® FL 830 ESH shows constant chemical reactions typical of an unalloyed flux. **Basicity according to Boniszewski:** ~4,6 **Flux density:** 1,0 - 1.1 kg / dm3 (l) **Grain size acc. to ISO 14174:** 2 – 16 **Current-carrying capacity:** up to **1.500 A DC** using one strip electrode 60 x 0.5 mm
CLASSIFICATIE	EN ISO 14174: ES A FB 2B 5644 DC
GESCHIKT VOOR	**Typical strip combinations:** **CEWELD SA 308L strip** ISO 14343-A: B 19 9 L AWS 5.9: EQ ER 308L **CEWELD SA 309LMo strip I**SO 14343-A: B 23 12 3L AWS 5.9: EQ ER 309L **CEWELD SA 309LNb strip** ISO 14343-A: B 23 12 L Nb AWS 5.9: ~EQ ER 309LNb **CEWELD SA 316L strip** ISO 14343-A: B 19 12 3L AWS 5.9: EQ ER 316L **CEWELD SA 347 strip** ISO 14343-A: B 19 9 AWS 5.9: EQ ER 347 **CEWELD SA 2209 strip** ISO 14343-A: B 22 9 3L AWS 5.9: EQ ER 2209 **CEWELD SA 904L strip** ISO 14343-A: B 20 25 5 CuL AWS 5.9: EQ ER 385L **Hardfacing:** **CEWELD SAS 550-VW** ISO 14700 : ~C Fe8 Hardness: HRc 52-58
GOEDKEURINGEN	CE
LASPOSITIES	

TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)

CaF2	CaO+MgO	SiO2+TiO2+Al2O3
70	5	20

MECHANISCHE WAARDEN

HERDROGEN	350°C / 2 hr
GAS ACC. EN ISO 14175	None



CEWELD FL 830 ESH

FL 830 ESH 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	25	8720663404152