



CEWELD FL 180

TYPE	Agglomerated aluminate rutile welding flux with pick up of Mn and Si, suitable for welding carbon steel.			
APPLICATIONS	CEWELD® FL 180 is preferably used for single pass , two run and fillet SAW welding. It is designed for all SAW processes and for welding common carbon-manganese, low-alloy structural and boiler steels with yield strengths up to 355 MPa (t < 25 mm) . The flux is suitable for high speed welding (up to 2 m/min.) and gives very good weld bead appearance and excellent slag release even on small angle preparation and fillet welds. Main applications include structural steelwork, thin walled containers, LPG cylinders and finned tube walls.			
PROPERTIES	CEWELD® FL 180 is an agglomerated aluminate rutile welding flux. Its chemical nature provides high resistance to cracking in single pass applications. Other features include resistance to porosity when welding rusty sheets, heavy scale or other sheet surface contaminants (e.g. special primer coatings) and low sensitivity to arc blow. Basicity according to Boniszewski: ~0,6 Flux density: 1.0 kg / dm3 (l) Grain size acc. to ISO 14174: 2 - 16; 2 – 12; 2 - 20 Current-carrying capacity: up to 800 A (DC or AC) using one wire			
CLASSIFICATION	EN ISO	14174: SA AR 1 76 AC H5		
SUITABLE FOR	Typical wire combinations: CEWELD® S1 ISO 14171-A: S 38 A AR S1 AWS 5.17_5.23: F48A0-EL12 F7AZ-EL12 CEWELD® S2 ISO 14171-A: S 42 0 AR S2 AWS 5.17_5.23: F48A0-EM12(K) F7AZ-EM12(K) CEWELD® S2Si ISO 14171-A: S 42 2 AR S2Si AWS 5.17_5.23: F48A2-EM12K F7A0-EM12K CEWELD® S2Mo ISO 14171-A: S 46 2 AR S2Mo AWS 5.17_5.23: F55A2-EA2-A2 F8A0-EA2-A2 CEWELD® S2CrMo1 ISO 24598-A: S S CrMo1 AR AWS 5.17_5.23: F55PZ-EB2-B2 F8PZ-EB2-B2			
APPROVALS				
WELDING POSITIONS	 PA  PB  PC			
TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)	Al2O3	CaF2	SiO2	CaO+MgO
	55	10	25	5
MECHANICAL PROPERTIES				
REDRYING	350°C / 2 hr			
GAS ACC. EN ISO 14175				



CEWELD FL 180

FL 180 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	27,5	8720663403964

FL 180 0,2 - 2,0MM

Packaging	KG/unit	EanCode
Bag	25	8720663403971