CEWELD FL 155

certilas® THE FILLER METAL SPECIALIST

TYPE

High basic SAW flux with very low hydrogen content

APPLICATIONS

CEWELD® FL 155 has a low hydrogen content after re-drying and, if the recommended temperature control is adhered to, optimum mechanical properties that enable the welding of thick-walled structural steels with yield strengths of up to 420 MPa.
Applicable for

- Offshore applications up to a yield strength of 550 MPa
- Fine-grain structural steels for low-temperature requirements with notched impact strengths of -60 °C and below
- High-strength fine-grain structural steels with yield strengths of up to 700 MPa are also possible

N-A-XTRA 70 Boiler and shipbuilding steels, drilling rigs, crane construction, offshore foundations, jack-ups, narrow gap welding, multi-layer welding.

PROPERTIES

CEWELD® FL 155 is an agglomerated fluoride basic flux with high basicity and low impurity levels such as P and S. As a result of the low oxygen levels in the weld deposits, uniform mechanical properties are achieved with high toughness values at low temperatures. Designed for multi-wire applications where high deposition rates and good slag removal are required, this flux shows excellent weldability and weld bead appearance.CEWELD® FL 155 is suitable for welding on D.C. and A.C. using single, tandem and multi-wire processes.

- Basicity according to Boniszewski: ~3,2
- Flux density: 0.95 kg/dm3 (l)
- Grain size acc. to ISO 14174: 2–20 (Tyler 8×65)
- Current-carrying capacity: up to 800 A (DC or AC) using one wire

CLASSIFICATION

EN ISO 14174: SA FB 1 55 AC H5

SUITABLE FOR

S355, S420, S460, S690, P500, P550, X65, X70, X80, Weldox 700, Naxtra 70, Hardox 400, Dilimax, P91, P24
Typical wire combinations:
CEWELD® S2 ISO 14171-A: S 38 6 FB S2 AWS 5.17_5.23:F48A6/P6-EM12(K) F7A8/P8-EM12(K)
CEWELD® S2Si ISO 14171-A: S 38 6 FB S2Si AWS 5.17_5.23:F48A6/P6-EM12K F7A8/P8-EM12K
CEWELD® S3Si ISO 14171-A: S 46 6 FB S3Si AWS 5.17_5.23:F55A6/F55P6-EH12K F8A8/F8P8-EH12K
CEWELD® S2Mo ISO 14171-A: S 46 4 FB S2Mo AWS 5.17_5.23:F55A4/F49P4-EA2-A2 F8A4/F7P4-EA2-A2
CEWELD® S2Ni3 ISO 14171-A: S 50 8 FB S2Ni3 AWS 5.17_5.23:F55A7/P7-ENi3-Ni3 F8A10/P10-ENi3-Ni3
CEWELD® S3NiMoCr ISO 26304-A: S 69 6 FB- S3Ni2,5CrMo AWS 5.17_5.23: F76A6/P6-EM4 mod.-M4 F11A8/P8-EM4 mod.-M4
CEWELD® SA 90S-B9 ISO 24598-A: S CrMo91 AWS 5.23: EB91
CEWELD® SACW 690 ISO 26304-A: S 69 6 FB T3Ni2,5CrMo AWS 5.23: F11A8-ECF5-F5

APPROVALS

TÜV: 12709, CE, Lloyds, DNV

WELDING POSITIONS

TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)

CaF2	SiO2	CaO+MgO+CaF2+MnO	S	P
26.5	9.8	68.4	0.018	0.025

MECHANICAL PROPERTIES

REDRYING

300°C / 2 hr

CEWELD FL 155

GAS ACC. EN ISO 14175

CEWELD FL 155

FL 155 0,2 - 2,0MM

Packaging	KG/unit	EanCode
Bag	20/25	8720663424006
Can	25	8720663424013