



CEWELD FL 838

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

CONVIENT POUR	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		
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AGRÉMENTS

POSITIONS DE SOUDAGE



COMPOSITION CHIMIQUE TYPIQUE EN POIDS (%)

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

PROPRIÉTÉS MÉCANIQUES

ETUVAGE	Not required
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GAS ACC. EN ISO 14175



CEWELD FL 838

FL 838 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	25	8720663404091