



# CEWELD FL 838

|                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                          |       |       |       |
|--------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------|-------|-------|-------|
| TYPE                                       | Agglomerated flux for SAW welding stainless steels and Nickel based alloys.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                          |       |       |       |
| APPLICATIONS                               | <p>CEWELD® FL 838 is designed for joint welding and surfacing.</p> <p>It is specifically designed for welding austenitic and austenitic-ferritic (duplex/superduplex) stainless steels (DSS) such as Grade 2205 (Duplex S31805/S32205 = 1.4462) or Grade 2507 (Superduplex S32750 = 1.4410).</p> <p><b>Austenitic CrNi(Mo) steels</b> (including Nb/Ti and ELC grades); resistant to intergranular corrosion in both as-welded and solution treated condition.</p> <p><b>High alloy CrNi(Mo) steels</b> for low temperature service and heat resistant steels</p> <p><b>Nickel base alloys</b> using NiCr and NiCrMo wire electrodes to AWS A5.14 / EN ISO 18274</p> <p><b>Welding of dissimilar metals</b> such as low alloy steels to stainless steels or special cryogenic steels (e.g. 9%Nisteel) in flat or 2G position.</p>                                                                                                                                                                                                                                                                      |                          |       |       |       |
| PROPERTIES                                 | <p>CEWELD® FL 838 is an <b>agglomerated aluminate-fluoride-basic Flux</b>. This basic but <b>neutral flux</b> gives excellent results on standard austenitic and heat resistant stainless steels when used with the appropriate wire electrodes according to EN ISO 14343 or ASME II C: SFA 5.9. It is also suitable for joint and overlay welding of nickel alloys when used with appropriate Ni-base wire electrodes.</p> <p><b>Basicity according to Boniszewski:</b> ~1,9</p> <p><b>Flux density:</b> 1.0 kg / dm3 (l)</p> <p><b>Grain size acc. to ISO 14174:</b> 2 – 16</p> <p><b>Current-carrying capacity:</b> up to 900 A DC using one wire</p>                                                                                                                                                                                                                                                                                                                                                                                                                                               |                          |       |       |       |
| CLASSIFICATION                             | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 14174: S A FB 2 55 53 AC |       |       |       |
| SUITABLE FOR                               | <p><b>Typical wire combinations</b></p> <p>CEWELD®SA 307 ISO 14343-A: ~S 18 8 Mn AWS 5.9: ER307</p> <p>CEWELD®SA 308L ISO 14343-A: ~S 19 9 L AWS 5.9: ER308L</p> <p>CEWELD®SA 309L ISO 14343-A: ~S 23 12 L AWS 5.9: ER309L</p> <p>CEWELD®SA 309LMo ISO 14343-A: ~S 23 12 3 L AWS 5.9: ~ER309LMo</p> <p>CEWELD®SA 310 ISO 14343-A: S 25 20 AWS 5.9: ER310</p> <p>CEWELD®SA 316L ISO 14343-A: S 19 12 3 L AWS 5.9: ER316L</p> <p>CEWELD®SA 317L ISO 14343-A: S 18 15 3 L AWS 5.9: ER317L</p> <p>CEWELD®SA 318 ISO 14343-A: S 12 12 3 Nb AWS 5.9: ER318</p> <p>CEWELD®SA 347 ISO 14343-A: S 19 9 Nb AWS 5.9: ER347</p> <p>CEWELD®SA 2209 ISO 14343-A: S 22 9 3 N L AWS 5.9: ER2209</p> <p>CEWELD®SA 904L ISO 14343-A: S 20 25 5Cu L AWS 5.9: ER385</p> <p>CEWELD®SA 2594 ISO 14343-A: 25 9 4 N L AWS 5.9: ER2594</p> <p><b>Hardfacing:</b></p> <p>CEWELD®SA 410NiMo ISO 14343-A: S 13 4 AWS 5.9: ER410NiMo Hardness: HRc ~380 after PWHT<br/>HB ~250</p> <p>CEWELD®SA 420B ISO 14343-B: 420 AWS 5.9: ER420 Hardness: HRc ~ 50</p> <p>CEWELD®SA 430 ISO 14343-A: S 17 AWS 5.9: ER430 Hardness: HB~ 250</p> |                          |       |       |       |
| APPROVALS                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                          |       |       |       |
| WELDING POSITIONS                          | <div>PAPBPC</div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                          |       |       |       |
| TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%) | CaF2                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Al2O3+CaO+MgO            | Al2O3 | S     | P     |
|                                            | 14                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 60                       | 24    | 0.037 | 0.013 |
| MECHANICAL PROPERTIES                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                          |       |       |       |
| REDRYING                                   | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                          |       |       |       |
| GAS ACC. EN ISO 14175                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                          |       |       |       |



# CEWELD FL 838

FL 838 0,3 - 1,4MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Bag       | 25      | 8720663404091 |