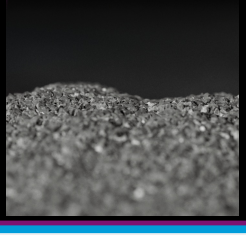


CEWELD FL 188

certilas® THE FILLER METAL SPECIALIST

TYPE

Agglomerated semi-basic flux suitable for carbon alloy steel welding in single and multipass technique and in single or multi-wire applications.

APPLICATIONS

CEWELD® FL 188 is designed for **joint welding** of unalloyed and low alloyed structural steels. Fine grained structural steels with **yield strengths up to 420 MPa** and boiler steels such as P265GH (H II) and 16Mo3/A335 grade 91.
Boiler work, pipes, shipbuilding, structural steelwork, tanks and pressure vessels, offshore applications, etc.

PROPERTIES

CEWELD® FL 188 is an **aluminate basic agglomerated** welding flux. It is suitable for joint welding of low alloy structural steels, pipe steels, boiler steels and fine grain steels. The flux is suitable for **single and multiple pass** longitudinal, circumferential and fillet welds. It can be used in single, tandem, twin and multiple wire welding systems. Excellent slag removal in narrow groove welds of thick wall sections. Typical characteristics of this flux are **medium Mn and Si pick-up** and very low diffusible hydrogen content. It is suitable for both AC and DC welding.
Basicity according to Boniszewski: ~1.7
Flux density: 1.1 kg/dm3 (l)
Grain size acc. to ISO 14174: 2–16 (Tyler 10×65)
Current-carrying capacity: up to 1.**500 A (DC or AC)** using one wire

CLASSIFICATION

EN ISO 14174: SA AB 1 68 AC H5

SUITABLE FOR

Typical wire combinations:
CEWELD® S1 ISO 14171-A: S 38 2 AB S1/ AWS 5.17_5.23: F48A2-EL12 F7A0-EL12
CEWELD® S2 ISO 14171-A: S 42 4 AB S2 AWS 5.17_5.23: F48A4/P4-EM12(K) F7A4/P4-EM12(K)
CEWELD® S2Si ISO 14171-A: S 42 4 AB S2Si AWS 5.17_5.23: F48A4/P4-EM12K F7A4/P4-EM12K
CEWELD® S3Si ISO 14171-A: S 46 4 AB S3Si AWS 5.17_5.23: F55A4/F48P4-EH12K F8A5/F7P4-EH12K
CEWELD® S2Mo ISO 14171-A: S 46 3 AB S2Mo AWS 5.17_5.23: F55A4/P4-EA2-A2 F8A2/P2-EA2-A2

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)

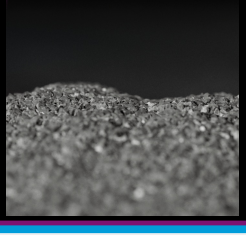
Al2O3	CaF2	Al2O3+CaO+MgO	S	P
22.3	19	45.6	0.017	0.025

MECHANICAL PROPERTIES

REDRYING

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD FL 188

FL 188 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	25	8720663403988
Bag	25	8720663403995

WWW.CERTILAS.COM/DISCLAIMER