CEWELD FL 838

certilas® THE FILLER METAL SPECIALIST

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: S A FB 2 55 53 AC

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

AGRÉMENTS

POSITIONS DE SOUDAGE

COMPOSITION CHIMIQUE TYPIQUE EN POIDS (%)

CaF2	Al2O3+CaO+MgO	Al2O3	S	P
14	60	24	0.037	0.013

PROPRIÉTÉS MÉCANIQUES

ETUVAGE Not required

GAS ACC. EN ISO 14175

CEWELD FL 838

FL 838 0,3 - 1,4MM

Packaging	KG/unit	EanCode
Bag	25	8720663404091

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