



CEWELD FL 838

TYPE	Agglomerated flux for SAW welding stainless steels and Nickel based alloys.			
APPLICATIONS	CEWELD® FL 838 is designed for joint welding and surfacing. 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). Austenitic CrNi(Mo) steels (including Nb/Ti and ELC grades); resistant to intergranular corrosion in both as-welded and solution treated condition. High alloy CrNi(Mo) steels for low temperature service and heat resistant steels Nickel base alloys using NiCr and NiCrMo wire electrodes to AWS A5.14 / EN ISO 18274 Welding of dissimilar metals such as low alloy steels to stainless steels or special cryogenic steels (e.g. 9%Nisteel) in flat or 2G position.			
PROPERTIES	CEWELD® FL 838 is an agglomerated aluminate-fluoride-basic Flux. This basic but neutral flux 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. Basicity according to Boniszewski: ~1,9 Flux density: 1.0 kg / dm3 (l) Grain size acc. to ISO 14174: 2 – 16 Current-carrying capacity: up to 900 A DC using one wire			
CLASSIFICATION	EN ISO	14174: SA AF 2 5644 DC H5		
SUITABLE FOR	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			
APPROVALS				
WELDING POSITIONS	 PA  PB  PC			
TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)	CaF2	CaO+MgO	SiO2+TiO2	Al2O3+MnO
	50	5	10	35
MECHANICAL PROPERTIES				
REDRYING	Not required			
GAS ACC. EN ISO 14175				



CEWELD FL 838

FL 838 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	25	8720663404091