

CEWELD FL 400

TYPE Agglomerated flux for SAW welding to obtain increased hardness with low and un-alloyed sub arc wires.

APPLICATIONS CEWELD® FL 400 is an **active SAW flux (C, Cr, Mo alloying characteristic)** designed for **hard surfacing** and joint welding of low alloyed wire electrodes. Reconditioning and hardfacing of parts subject to impact and wear, such as piston rod ends, mining parts, excavator parts, rolling bars, pressure rollers, cement rollers, dredging parts, coupling parts, crushing hammers, etc...

PROPERTIES CEWELD® FL 400 is an **agglomerated calcium-silicate** flux. It exhibits the constant chemical reactions typical of our alloyed fluxes.
Basicity according to Boniszewski: ~1.7
Flux density: 1.2–1.3 kg/dm³ (l)
Grain size acc. to ISO 14174: 2–16 (Tyler 10×65)
Current-carrying capacity: up to **800 A DC** using one wire 4.0 mm

CLASSIFICATION EN ISO 14174: SA CS 3 99 CCrMo AC

SUITABLE FOR **Typical wire combinations CEWELD® S2 :**
 1 L : C~ 0,12 / Mn ~1,3 / Si 0,6 / Cr ~ 1,3 / Mo~ 0,15 As welded 270 HB
 2 L : C~ 0,12 / Mn ~1,5 / Si 0,7 / Cr ~ 1,7 / Mo~ 0,20 As welded 330 HB
 3 L : C~ 0,12 / Mn ~1,7 / Si 0,9 / Cr ~ 1,8 / Mo~ 0,25 As welded 340 HB

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)	CaF2	CaO+MgO	SiO2+TiO2+Al2O3
	10	25	55

MECHANICAL PROPERTIES

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175

CEWELD FL 400

FL 400 0,4-1,8MM

Packaging	KG/unit	EanCode
Bag	25	8720663404961