

CEWELD FL 400

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

APPLICATIONS Rebuilding and hardfacing parts that suffer from impact and wear as in Mining, Dredging etc.

PROPRIÉTÉS CEWELD® FL 400 is an agglomerated flux for SAW welding to obtain increased hardness with low and un-alloyed sub arc wires. Basicity: about 1,1 (according to Boniszewski) Current: DC or AC, in single or multi-wires Grain size: 2-16

CLASSIFICATION EN ISO 14174: SA CS 3 99 CCrMo AC

CONVIENT POUR **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

AGRÉMENTS

POSITIONS DE SOUDAGE



**COMPOSITION CHIMIQUE
 TYPIQUE EN POIDS (%)**

CaF2	CaO+MgO	SiO2+TiO2+Al2O3
10	25	55

PROPRIÉTÉS MÉCANIQUES

ETUVAGE Not required

GAS ACC. EN ISO 14175

CEWELD FL 400

FL 400 0,4-1,8MM

Packaging	KG/unit	EanCode
Bag	25	8720663404961