

CEWELD FL 400

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

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

EIGENSCHAPPEN 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

CLASSIFICATIE EN ISO 14174: SA CS 3 99 CCrMo AC

GESCHIKT VOOR **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

GOEDKEURINGEN

LASPOSITIES



TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)

CaF ₂	CaO+MgO	SiO ₂ +TiO ₂ +Al ₂ O ₃
10	25	55

MECHANISCHE WAARDEN

HERDROGEN Not required

GAS ACC. EN ISO 14175

CEWELD FL 400

FL 400 0,4-1,8MM

Packaging	KG/unit	EanCode
Bag	25	8720663404961