



CEWELD FL 860 ESHC

TYPE	High basic agglomerated flux for welding Nickel based strips with the elctro slag process.		
ANWENDUNGEN	Designed for ES strip cladding in offshore, apparatus, vessel, boilers and chemical industry.		
EIGENSCHAFTEN	FL 860 ESHC is a highly basic flux for Nickel based strip electro slag cladding. Basicity: about 4,2 (according to Boniszewski) Current: DC + Grain size: 2-16		
KLASSIFIKATION	EN ISO	14174: ES A FB 2B 5644 DC	
GEEIGNET FÜR	Typical strip combinations: CEWELD SA Nicro 600 strip ISO 18274: S Ni 6082 (NiCr20Mn3Nb) AWS 5.14: EQNiCr-3 (UNS N06082) CEWELD SA Nicro 602 CA (6025HT) strip ISO 18274: S Ni6025 (NiCr25Fe10AlY) AWS 5.14: EQNiCrFe-12 (UNS N06025) CEWELD SA Nicro 625 strip ISO 18274: S Ni 6625(NiCr22Mo9Nb) AWS 5.14: EQNiCrMo-3 (UNS N06625) CEWELD SA Alloy 825 strip ISO 18274: S Ni 8065(NiFe30Cr21Mo3Cu3) AWS 5.14: EQNiFeCr-1 (UNS N08065)		
ZULASSUNGEN			
SCHWEISSPOSITIONEN			
TYPISCHE CHEMISCHE ZUSAMMENSETZUNG NACH GEWICHT (%)	CaF2	SiO2	CaO+MgO
	70	20	5
MECHANISCHE GÜTEWERTE			
RÜCKTROCKNUNG	Not required		
GAS ACC. EN ISO 14175			



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FL 860 ESHC 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	25	8720663404213