



# CEWELD FL 838

|                |                                                                                                                                                                                                                                           |                           |  |
|----------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|--|
| TYPE           | Agglomerated flux for SAW welding stainless steels and Nickel based alloys.                                                                                                                                                               |                           |  |
| ANWENDUNGEN    | Vessels, tanks, boilers, steam turbines, shafts, valves, cladding steel rollers with stainless steel and Nickel based alloys                                                                                                              |                           |  |
| EIGENSCHAFTEN  | FL 838 is an agglomerated flux for SAW welding stainless steels and Nickel based alloys: AISI 308L, 347, 316L, 309L and 309LN. Basicity: About 1,9 (according to Boniszewski) Current: DC or AC, in single or multi-wires Grain size: 2-1 |                           |  |
| KLASSIFIKATION | EN ISO                                                                                                                                                                                                                                    | 14174: SA AF 2 5644 DC H5 |  |

|                    |                                                                                                        |  |                    |
|--------------------|--------------------------------------------------------------------------------------------------------|--|--------------------|
| GEEIGNET FÜR       | <b>Typical wire combinations</b>                                                                       |  |                    |
|                    | 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                                                    |  |                    |
| ZULASSUNGEN        | 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                                                 |  |                    |
|                    | <b>Hardfacing:</b>                                                                                     |  |                    |
|                    | CEWELD®SA 410NiMo ISO 14343-A: S 13 4 AWS 5.9: ER410NiMo      Hardness: HRc ~380 after PWHT<br>HB ~250 |  |                    |
| SCHWEISSPOSITIONEN | 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  |



|                                                           |      |         |           |           |
|-----------------------------------------------------------|------|---------|-----------|-----------|
| TYPISCHE CHEMISCHE<br>ZUSAMMENSETZUNG NACH<br>GEWICHT (%) | CaF2 | CaO+MgO | SiO2+TiO2 | Al2O3+MnO |
|                                                           | 50   | 5       | 10        | 35        |

## MECHANISCHE GÜTEWERTE

|               |              |
|---------------|--------------|
| RÜCKTROCKNUNG | Not required |
|---------------|--------------|

GAS ACC. EN ISO 14175



# CEWELD FL 838

FL 838 0,2 - 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Bag       | 25      | 8720663404091 |