CEWELD[®]

FL 180F

CATEGORY	SAW Submerged arc					
ТҮРЕ	Agglomerated rutile flux additive in Mn and Si, suitable for carbon steel welding with two or three passes.					
APPLICATIONS	Light boiler works, beams, pipes, ship building, structural steel works, small tanks and gas cylinders etc					
PROPERTIES	Excellent slag removal in fillet and root passes. It can be used in single or multi-wires at high speed with excellent bead aspect. Ceweld S4 wire in combination with this flux is suitable only for fillet welding in single pass. Excellent slag removal in fillet and groove welds. Basicity: About 0,4 (according to boniszewski) Current: DC or AC, in single or multi-wires up to 1200 Ampere per wire Grain size: According to EN 760: 2-20 specification					
CLASSIFICATION	AWS EN ISO DIN	5.17: F6A2-EL12 5.17: F7A3-EM12K 14174: SA AR 1 88 AC BAR 188AC10KM				
SUITABLE FOR	Unalloyed steels:St 33 – St 52 Ship building: A, E, AH, EH, Boiler steels: HI-HIII, 17Mn4, 19Mn5, Pipe steels: St 37.0/4 – St 52.0/4, Fine-grain steels:StE 255 – StE 420					
APPROVALS	CE approved	d				
WELDING POSITIONS:						

NOMINAL FLUX COMPOSITION

MnO	TiO ₂	CaO	FeF ₂	Fe ₂ O ₃	SiO ₂	Al ₂ O ₃	MgO	P ₂ O ₅	CaF ₂
13	10	0,5	-	-	19	42	4	-	7

MECHANICAL PROPERTIES

AW	R _{P0,2}	Rm	A5		Hardness		
Wire type	(N/mm ²)	(N/mm ²)	(%)	0°C	-20°C	-60°C	HRc / HV
S1	>400	510-650	>22	>40	>27		
S2	>400	520-650	>22	>50	>27		
S2Si	>400	520-650	>22	>50	>27		
S4	>400	540-650	>22	>40	>27		
	-	-			-	•	

AW: as welded

REDRYING TEMPERATURE At 350°C for 2 hours to obtain diffusible hydrogen 5 ml/100 gr.