CEWELD®

FL 915

CATEGORY	SAW Submerged arc
TYPE	Agglomerated high speed basic flux for the SAW process.
APPLICATIONS	Steel mill rollers, boiler works, pipes, ship building, structural steel works, tanks and pressure vessels, piston cladding, offshore applications etc
PROPERTIES	Suitable for carbon (low alloy) and 13% Chromium alloy steel welding in single, multi-pass and multi wire applications (up to 5 wires) with very high welding speed. Recommended for weaving in cladding applications. The weld deposit produced in combination with corresponding sub-arc wires meets outstanding mechanical properties and in particular high toughness at low temperature. Excellent slag removal in fillet and groove welds even in extreme hot conditions. - **Basicity:** 2,2 (according to boniszewski) **Grain size:** 2.0-0.28mm (10-60 meshes).
CLASSIFICATION	AWS A 5.17: EM 12K 5.17: F8A6-EH 12K EN ISO 14174: SA FB 1 65 DC DIN 32522: BFB 165DC
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 460 (S460)
APPROVALS	CE approved
WELDING POSITIONS:	

NOMINAL FLUX COMPOSITION

SiO_2+TiO_2	MnO+Al_2O_3	CaO+MgO	CaF_2	H2O	S	P
19	27	31	19	0.03	<0,024	<0,024

Current: DC or AC, in single or multi-wires up to 1000 Ampere per wire

MECHANICAL PROPERTIES

	Classification of wire / flux combinations acc. to EN and AWS:		
Wire	EN 756 (rsg)en 1597-1, type 3	Two run EN 1597-1, type 4	AWS A 5.17 / A 5.23
S2	EN 756 - S 38 4 FB S2	EN 756 - S-3T 3 FB S2	F7 A6-EM 12 (K)
S3(Si)	EN 756 - S 42 4 FB S3	EN 756 - S 4T 3 FB S3	F8 A6-EH 12 K
S2Mo	EN 756 - S 46 3 FB S2Mo	EN 756 - S 4T 3 F8 S2Mo	F8 P4-EA2-A2
S2Ni1	EN 756 - S 42 6 FB S2Ni1	EN 756 - S 4T 3 FB S2Ni1	F7P8-ENi1-Ni1
S3NiMo1	EN 756 - S 50 3 FB S3Ni1Mo	EN 756 - S 5T 3 FB S3Ni1Mo	F9P4-EF3-F3
S4Mo	-	EN 756 - S 5T 3 FB S4Mo	F9A4-EA3-A3
S1 CrMo5	-	EN 756 - S 4T 2 FB SCrMo5	F8 PZ-EB6-B6

REDRYING TEMPERATURE	At 300-350ºC/2hr to obtain diffusible hydrogen 5 ml/100 gr. Max.
PACKING	In paper / plastic bags of 25 kg