

|                |                                                                                                                                                                                                                                        |                            |
|----------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|
| CATEGORY       | SAW Arc Submerged                                                                                                                                                                                                                      |                            |
| TYPE           | Agglomerated flux for SAW welding to obtain increased hardness with low and un-alloyed sub arc wires.                                                                                                                                  |                            |
| APPLICATIONS   | Rebuilding and hardfacing parts that suffer from impact and wear as in Mining, Dredging etc.                                                                                                                                           |                            |
| PROPERTIES     | 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 |                            |
| CLASSIFICATION | EN ISO                                                                                                                                                                                                                                 | 14174: SA CS 3 99 CCrMo AC |
| SUITABLE FOR   | Piston rod ends, mining parts, excavator parts, rolling bars, pressure rolls, cement rollers, dredging parts, coupling parts, crushing hammers. etc..                                                                                  |                            |
| APPROVALS      | No Approvals Found                                                                                                                                                                                                                     |                            |

WELDING POSITIONS:



TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)

| Al2O3 | CaF2 | SiO2 | CaO+MgO |
|-------|------|------|---------|
| 15    | 10   | 35   | 25      |

WELDING PARAMETERS / PACKING

| WELDING PARAMETERS | WELDING PARAMETERS | WELDING PARAMETERS | WELDING PARAMETERS    | WELDING PARAMETERS |
|--------------------|--------------------|--------------------|-----------------------|--------------------|
| D (MM)             | VOLTAGE (V)        | CURRENT (A)        | TRAVEL SPEED (CM/MIN) | STICK OUT (MM)     |
| 4,0                | 32                 | 600                | 50                    | 30-40              |

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175