



# CEWELD FL 880

**TYPE** Fused 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 880 is a fused flux for SAW welding stainless steels and Nickel based alloys. Basicity: about 1,3 (according to Boniszewski) Current: DC or AC, in single or multi-wires Grain size: 1-16

**KLASSIFIKATION** EN ISO 14174: SF CS 2 5742 DC

**GEEIGNET FÜR** S355, S420, S460, S690, P500, P550, X65, X70, X80, Weldom 700, Naxtra 70, Hardox 400, Dilimax, P91, P24

**ZULASSUNGEN**

**SCHWEISSPOSITIONEN**



**TYPISCHE CHEMISCHE ZUSAMMENSETZUNG NACH GEWICHT (%)**

Al2O3	CaF2	SiO2	CaO+MgO
5	20	30	35

**MECHANISCHE GÜTEWERTE**

**RÜCKTROCKNUNG** Not required

**WIRE & FLUX COMBINATION** Typical wire combinations: CEWELD® S2Mo ISO 14171-A: S 46 2 AR S2Mo AWS 5.17\_5.23: EA2 CEWELD® S2CrMo1 ISO 24598-A: S CrMo1 AWS 5.17\_5.23: EB2(R) CEWELD® S2CrMo2 24598-A: S Z CrMo2Mn AWS 5.17\_5.23:EB3 CEWELD® S2CrMo5 ISO 24598-A: S CrMo5 AWS 5.17\_5.23: EB6 CEWELD® SA 80S-B8 ISO 24598-A: S CrMo9 AWS 5.17\_5.23: EB8 CEWELD® SA 90S-B9 ISO 24598-A: S CrMo91 AR AWS 5.17\_5.23: EB91 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 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 CEWELD®SA Nicro 600 ISO 18274-A: S Ni 6082 (NiCr20Mn3Nb) AWS 5.14: ERNiCr-3 CEWELD®SA Nicro 625 ISO 18274-A: S Ni 6625 (NiCr22Mo9Nb) AWS 5.14: ERNiCrMo-3 CEWELD®SA Alloy 825 ISO 18274-A: S Ni8065 (NiFe30Cr21Mo3) AWS 5.14: ERNiFeCr-1 CEWELD®SA Alloy C-276 ISO 18274-A: S Ni 6276 (NiCr15Mo16Fe6W4) AWS 5.14: ERNiCrMo-4

**GAS ACC.** EN ISO 14175



# CEWELD FL 880

FL 880 0,1 - 1,6MM

Packaging	KG/unit	EanCode
Bag	15/25	8720663404114