



# CEWELD FL 180

**TYPE** 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** FL 180 is an agglomerated rutile flux with Mn and Si pick-up, suitable for carbon steel welding with two or three passes. Basicity: about 0,4 (according to Boniszewski) Current: DC or AC, in single or multi-wires Grain size: 2-20

**CLASSIFICATION** EN ISO 14174: SA AR 1 76 AC H5

**SUITABLE FOR**  
**S2Mo:** EN: 16Mo3, S(P)355-S(P)420, L245-L450 / ASME: API 5L Grades A, B, X42, X46, X52, X56  
**S1:** EN: S(P)235-S(P)355; L245-L360 / ASME: ASTM A131 Grades A, B, D, DS; A253 all Grades; A529 Grades 42, 50; A570 all Grades; A572 Grades 42, 50; A709 Grades 36, 50  
**S2:** EN: S(P)235-S(P)355; L245-L360 / ASME: ASTM A131 Grades A, B, D, DS; A253 all Grades; A529 Grades 42, 50; A570 all Grades; A572 Grades 42, 50; A709 Grades 36, 50

**APPROVALS**

**WELDING POSITIONS**



TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)	Al2O3	CaF2	SiO2	CaO+MgO
	55	10	25	5

**MECHANICAL PROPERTIES**

**REDRYING** 350°C / 2 hr

**GAS ACC.** EN ISO 14175



# CEWELD FL 180

FL 180 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	27,5	8720663403964

FL 180 0,2 - 2,0MM

Packaging	KG/unit	EanCode
Bag	25	8720663403971