



CEWELD FL 838

TYPE	Agglomerated 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 838 is an agglomerated flux for SAW welding stainless steels and Nickel based alloys: AISI 308L, 347, 316L, 309L and 309LN. Basicity: About 1,9 (according to Boniszewski) Current: DC or AC, in single or multi-wires Grain size: 2-1		
KLASSIFIKATION	EN ISO	14174: SA AF 2 5644 DC H5	

GEEIGNET FÜR

Typical wire combinations

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 309L Mo ISO 14343-A: ~S 23 12 3 L AWS 5.9: ~ER309L Mo

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

Hardfacing:

CEWELD®SA 410NiMo ISO 14343-A: S 13 4 AWS 5.9: ER410NiMo Hardness: HRc ~380 after PWHT

HB ~250

CEWELD®SA 420B ISO 14343-B: 420 AWS 5.9: ER420 Hardness: HRc ~ 50

CEWELD®SA 430 ISO 14343-A: S 17 AWS 5.9: ER430 Hardness: HB~ 250

ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPISCHE CHEMISCHE ZUSAMMENSETZUNG NACH GEWICHT (%)

CaF ₂	CaO+MgO	SiO ₂ +TiO ₂	Al ₂ O ₃ +MnO
50	5	10	35

MECHANISCHE GÜTEWERTE

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175



CEWELD FL 838

FL 838 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	25	8720663404091