CEWELD FL 400

TYPE	Agglomerated flux for SAW welding to obtain increased hardness with low and un-alloyed sub arc wires.
APPLICATIONS	CEWELD® FL 400 is an **active SAW flux (C, Cr, Mo alloying characteristic)** designed for **hard surfacing** and joint welding of low alloyed wire electrodes. Reconditioning and hardfacing of parts subject to impact and wear, such as piston rod ends, mining parts, excavator parts, rolling bars, pressure rollers, cement rollers, dredging parts, coupling parts, crushing hammers, etc...
PROPERTIES	CEWELD® FL 400 is an **agglomerated calcium-silicate** flux. It exhibits the constant chemical reactions typical of our alloyed fluxes. **Basicity according to Boniszewski:** ~1.7 **Flux density:** 1.2–1.3 kg/dm3 (l) **Grain size acc. to ISO 14174:** 2–16 (Tyler 10×65) **Current-carrying capacity:** up to **800 A DC** using one wire 4.0 mm
CLASSIFICATION	EN ISO 14174: SA CS 3 99 CCrMo AC
SUITABLE FOR	**Typical wire combinations CEWELD® S2 :** 1 L : C~ 0,12 / Mn ~1,3 / Si 0,6 / Cr ~ 1,3 / Mo~ 0,15 As welded 270 HB 2 L : C~ 0,12 / Mn ~1,5 / Si 0,7 / Cr ~ 1,7 / Mo~ 0,20 As welded 330 HB 3 L : C~ 0,12 / Mn ~1,7 / Si 0,9 / Cr ~ 1,8 / Mo~ 0,25 As welded 340 HB
APPROVALS	No Approvals Found
WELDING POSITIONS	

TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)

CaF2	CaO+MgO	SiO2+TiO2+Al2O3
10	25	55

REDRYING TEMPERATURE	300°C / 2 hr
GAS ACCORDING EN 14175	

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	Type	KG/unit	EANCode
FL 400 0,4-1,8MM	Bag	25	8720663404961