




# CEWELD FL 839

TYPE	Agglomerated high basic flux for SAW welding with Nickel based wires								
APPLICATIONS	Joining and cladding of: – Nickel-base alloys using NiCr- and NiCrMo- wire electrodes acc. to AWS A5.14 / EN ISO 18274 – Welding dissimilar steels such as low alloy steel with Nickel base alloys.								
PROPERTIES	FL 839 is a highly basic agglomerated welding flux - specially designed for a wide range of nickel alloys. Nickel based welding wires that are covered in AWS A 5.14 such as alloy 82, Inconel 600, 625, 601, 825, C276, alloy 59 etc. Basicity: about 3,3 (according to Boniszewski) Current: DC +, in single or multi-wires Grain size: 2-16								
CLASSIFICATION	EN ISO 14174: SA FB 2 DC								
SUITABLE FOR	Nickel based welding wires that are covered in AWS A 5.14 such as alloy 82, Inconel 600, 625, 601, 825, C276, alloy 59 etc.								
APPROVALS	No Approvals Found								
WELDING POSITIONS									
TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)	<table border="1"><thead><tr><th>Al<sub>2</sub>O<sub>3</sub></th><th>CaF<sub>2</sub></th><th>SiO<sub>2</sub></th><th>CaO+MgO</th></tr></thead><tbody><tr><td>35</td><td>50</td><td>10</td><td>5</td></tr></tbody></table>	Al <sub>2</sub> O <sub>3</sub>	CaF <sub>2</sub>	SiO <sub>2</sub>	CaO+MgO	35	50	10	5
Al <sub>2</sub> O <sub>3</sub>	CaF <sub>2</sub>	SiO <sub>2</sub>	CaO+MgO						
35	50	10	5						
REDRYING TEMPERATURE	Not required								
GAS ACCORDING EN 14175									



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FL 839 0,2 - 1,6MM

Type	KG/unit	EANCode
Bag	25	8720663404107