




CEWELD FL 155

TYPE	High basic SAW flux with very low hydrogen content								
APPLICATIONS	<p>CEWELD® FL 155 has a low hydrogen content after re-drying and, if the recommended temperature control is adhered to, optimum mechanical properties that enable the welding of thick-walled structural steels with yield strengths of up to 420 MPa.</p> <p>Applicable for</p> <ul style="list-style-type: none"> • Offshore applications up to a yield strength of 550 MPa • Fine-grain structural steels for low-temperature requirements with notched impact strengths of -60 °C and below • High-strength fine-grain structural steels with yield strengths of up to 700 MPa are also possible <p>N-A-XTRA 70 Boiler and shipbuilding steels, drilling rigs, crane construction, offshore foundations, jack-ups, narrow gap welding, multi-layer welding.</p>								
PROPERTIES	<p>CEWELD® FL 155 is an agglomerated fluoride basic flux with high basicity and low impurity levels such as P and S. As a result of the low oxygen levels in the weld deposits, uniform mechanical properties are achieved with high toughness values at low temperatures. Designed for multi-wire applications where high deposition rates and good slag removal are required, this flux shows excellent weldability and weld bead appearance. CEWELD® FL 155 is suitable for welding on D.C. and A.C. using single, tandem and multi-wire processes.</p> <ul style="list-style-type: none"> • Basicity according to Boniszewski: ~3,2 • Flux density: 0.95 kg/dm³ (l) • Grain size acc. to ISO 14174: 2-20 (Tyler 8×65) • Current-carrying capacity: up to 800 A (DC or AC) using one wire 								
CLASSIFICATION	EN ISO 14174: SA FB 1 55 AC H5								
SUITABLE FOR	<p>S355, S420, S460, S690, P500, P550, X65, X70, X80, Weldox 700, Naxtra 70, Hardox 400, Dilimax, P91, P24</p> <p>Typical wire combinations:</p> <p>CEWELD® S2 ISO 14171-A: S 38 6 FB S2 AWS 5.17_5.23:F48A6/P6-EM12(K) F7A8/P8-EM12(K)</p> <p>CEWELD® S2Si ISO 14171-A: S 38 6 FB S2Si AWS 5.17_5.23:F48A6/P6-EM12K F7A8/P8-EM12K</p> <p>CEWELD® S3Si ISO 14171-A: S 46 6 FB S3Si AWS 5.17_5.23:F55A6/F55P6-EH12K F8A8/F8P8-EH12K</p> <p>CEWELD® S2Mo ISO 14171-A: S 46 4 FB S2Mo AWS 5.17_5.23:F55A4/F49P4-EA2-A2 F8A4/F7P4-EA2-A2</p> <p>CEWELD® S2Ni3 ISO 14171-A: S 50 8 FB S2Ni3 AWS 5.17_5.23:F55A7/P7-ENi3-Ni3 F8A10/P10-ENi3-Ni3</p> <p>CEWELD® S3NiMoCr ISO 26304-A: S 69 6 FB- S3Ni2,5CrMo AWS 5.17_5.23: F76A6/P6-EM4 mod.-M4 F11A8/P8-EM4 mod.-M4</p> <p style="padding-left: 100px;">CEWELD® SA 90S-B9 ISO 24598-A: S CrMo91 AWS 5.23: EB91</p> <p>CEWELD® SACW 690 ISO 26304-A: S 69 6 FB T3Ni2,5CrMo AWS 5.23: F11A8-ECF5-F5</p>								
APPROVALS	TÜV (12709) CE Lloyds DNV								
WELDING POSITIONS									
TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">Al₂O₃</td> <td style="width: 25%;">CaF₂</td> <td style="width: 25%;">SiO₂</td> <td style="width: 25%;">CaO+MgO</td> </tr> <tr> <td>20</td> <td>25</td> <td>15</td> <td>40</td> </tr> </table>	Al ₂ O ₃	CaF ₂	SiO ₂	CaO+MgO	20	25	15	40
Al ₂ O ₃	CaF ₂	SiO ₂	CaO+MgO						
20	25	15	40						
REDRYING TEMPERATURE	300°C / 2 hr								
GAS ACCORDING EN 14175									



CEWELD FL 155

FL 155 0,2 - 2,0MM

Type	KG/unit	EANCode
Bag	20/25	8720663424006
Can	25	8720663424013