




CEWELD FL 880

TYPE	Fused flux for SAW welding stainless steels and Nickel based alloys.								
APPLICATIONS	<p>CEWELD® FL 880 is also suitable for welding both low alloy steels for use at elevated temperatures and in combination with austenitic stainless steels.</p> <p>It is suitable for joint welding and surfacing of:</p> <p>creep resistant CrMo steels for boiler, vessel and pipe fabrication</p> <p>Martensitic and ferritic Cr(NiMo) steels with the appropriate wire electrodes and heat treatments</p> <p>Austenitic CrNi(Mo) steels (including ELC grades) resistant to intergranular corrosion in both as-welded and solution treated condition</p> <p>High alloy CrNi(Mo) steels for low temperature service and heat resistant steels</p> <p>High-alloy Cr(NiMo) steels in combination with low-alloy steels (dissimilar joints)</p> <p>Nickel base alloys using NiCr and NiCrMo wire electrodes.</p>								
PROPERTIES	<p>CEWELD® FL 880 is a specially designed glassy fused welding flux for austenitic stainless steels. As a result of the semi-basic flux characteristics, crack free welds can be achieved on most stainless steel grades when welded with the appropriate wire electrodes. The metallurgical behaviour of the flux is neutral (C neutral, low Si pick-up and low Mn burn-out) without Cr compensation.</p> <p>It is suitable for DC single or DC/AC multi-wire welding and produces smooth, slag free weld beads with flat weld interfaces even in narrow gaps and on preheated workpieces.</p> <p>Basicity according to Boniszewski: ~1,3</p> <p>Flux density: 1.5 kg / dm³ (l)</p> <p>Grain size acc. to ISO 14174: 1 – 16</p> <p>Current-carrying capacity: up to 900 A DC using one wire or DC/AC multi-wire</p>								
CLASSIFICATION	EN ISO 14174: SF CS 2 5742 DC								
SUITABLE FOR	S355, S420, S460, S690, P500, P550, X65, X70, X80, Weldox 700, Naxtra 70, Hardox 400, Dilimax, P91, P24								
APPROVALS	No Approvals Found								
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>5</td> <td>20</td> <td>30</td> <td>35</td> </tr> </table>	Al ₂ O ₃	CaF ₂	SiO ₂	CaO+MgO	5	20	30	35
Al ₂ O ₃	CaF ₂	SiO ₂	CaO+MgO						
5	20	30	35						
REDRYING TEMPERATURE	Not required								
GAS ACCORDING EN 14175									



CEWELD FL 880

FL 880 0,1 - 1,6MM

Type	KG/unit	EANCode
Bag	15/25	8720663404114