

CEWELD FL 180

TYPE	Agglomerated aluminate rutile welding flux with pick up of Mn and Si, suitable for welding carbon steel.									
APPLICATIONS	<p>CEWELD® FL 180 is preferably used for single pass, two run and fillet SAW welding. It is designed for all SAW processes and for welding common carbon-manganese, low-alloy structural and boiler steels with yield strengths up to 355 MPa (t < 25 mm). The flux is suitable for high speed welding (up to 2 m/min.) and gives very good weld bead appearance and excellent slag release even on small angle preparation and fillet welds.</p> <p>Main applications include structural steelwork, thin walled containers, LPG cylinders and finned tube walls.</p>									
PROPERTIES	<p>CEWELD® FL 180 is an agglomerated aluminate rutile welding flux. Its chemical nature provides high resistance to cracking in single pass applications. Other features include resistance to porosity when welding rusty sheets, heavy scale or other sheet surface contaminants (e.g. special primer coatings) and low sensitivity to arc blow.</p> <p>Basicity according to Boniszewski: ~0,6</p> <p>Flux density: 1.0 kg / dm³ (l)</p> <p>Grain size acc. to ISO 14174: 2 - 16; 2 - 12; 2 - 20</p> <p>Current-carrying capacity: up to 800 A (DC or AC) using one wire</p>									
CLASSIFICATION	EN ISO	14174: SA AR 1 76 AC H5								
SUITABLE FOR	<p>Typical wire combinations:</p> <p>CEWELD® S1 ISO 14171-A: S 38 A AR S1 AWS 5.17_5.23: F48A0-EL12 F7AZ-EL12</p> <p>CEWELD® S2 ISO 14171-A: S 42 0 AR S2 AWS 5.17_5.23: F48A0-EM12(K) F7AZ-EM12(K)</p> <p>CEWELD® S2Si ISO 14171-A: S 42 2 AR S2Si AWS 5.17_5.23: F48A2-EM12K F7A0-EM12K</p> <p>CEWELD® S2Mo ISO 14171-A: S 46 2 AR S2Mo AWS 5.17_5.23: F55A2-EA2-A2 F8A0-EA2-A2</p> <p>CEWELD® S2CrMo1 ISO 24598-A: S S CrMo1 AR AWS 5.17_5.23: F55PZ-EB2-B2 F8PZ-EB2-B2</p>									
APPROVALS	No Approvals Found									
WELDING POSITIONS	  									
TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)	<table border="1" style="width: 100%; text-align: center;"> <tr> <td>Al₂O₃</td><td>55</td><td>CaF₂</td><td>10</td><td>SiO₂</td><td>25</td><td>CaO+MgO</td><td>5</td></tr> </table>		Al ₂ O ₃	55	CaF ₂	10	SiO ₂	25	CaO+MgO	5
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REDRYING TEMPERATURE	350°C / 2 hr									
GAS ACCORDING EN 14175										

CEWELD FL 180

FL 180 0,2 - 1,6MM

Type	KG/unit	EANCode
Bag	27,5	8720663403964

FL 180 0,2 - 2,0MM

Type	KG/unit	EANCode
Bag	25	8720663403971