CEWELD FL 180

certilas® THE FILLER METAL SPECIALIST

TYPE	Agglomerated aluminate rutile welding flux with pick up of Mn and Si, suitable for welding carbon steel.
APPLICATIONS	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. Main applications include structural steelwork, thin walled containers, LP gas cylinders and **finned tube** walls.
PROPERTIES	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. **Basicity according to Boniszewski:** ~0,6 **Flux density:** 1.0 kg / dm3 (l) **Grain size acc. to ISO 14174:** 2 - 16; 2 – 12; 2 - 20 **Current-carrying capacity:** up to **800 A (DC or AC)** using one wire
CLASSIFICATION	EN ISO 14174: SA AR 1 76 AC H5
SUITABLE FOR	**Typical wire combinations:** **CEWELD® S1** ISO 14171-A: S 38 A AR S1 AWS 5.17_5.23: F48A0-EL12 F7AZ-EL12 **CEWELD® S2** ISO 14171-A: S 42 0 AR S2 AWS 5.17_5.23: F48A0-EM12(K) F7AZ-EM12(K) **CEWELD® S2Si** ISO 14171-A: S 42 2 AR S2Si AWS 5.17_5.23: F48A2-EM12K F7A0-EM12K **CEWELD® S2Mo** ISO 14171-A: S 46 2 AR S2Mo AWS 5.17_5.23: F55A2-EA2-A2 F8A0-EA2-A2 **CEWELD® S2CrMo1** ISO 24598-A: S S CrMo1 AR AWS 5.17_5.23: F55PZ-EB2-B2 F8PZ-EB2-B2
APPROVALS	No Approvals Found
WELDING POSITIONS	

TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)

Al2O3	CaF2	SiO2	CaO+MgO
55	10	25	5

REDRYING TEMPERATURE 350°C / 2 hr

GAS ACCORDING EN 14175

CEWELD FL 180

certilas® THE FILLER METAL SPECIALIST

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