CEWELD FL 165

TYPE	Medium basic SAW flux for Single and multi-wire in layer/counter layer or multiple layers.
APPLICATIONS	CEWELD® FL 165 is a medium base powder for joint welding of low alloy structural steels, fine grained structural steels, boiler steels and especially all pipe and marine steels. Excellent weldability with single and multiple wires (up to 5 wires), in layer/counter-layer or multi-layer passes. Also in combination with cored wire and solid wire. Typical applications: Shipbuilding, spiral and longitudinal tube production of structural pipe steels from L360 or X52 to L555 or X80 according to ISO3183 / API-5L. Unalloyed and low-alloyed structural steels according to EN 10025; fine-grained structural steels up to 700 MPa yield strength while maintaining material-specific properties; boiler structural steels such as 16Mo3 and 13CrMo4-5.
PROPERTIES	CEWELD® FL 165 has a very low hydrogen content of less than 5 ml/100 g in the weld metal, an oxygen content of around 350 ppm and a low nitrogen content of less than 70 ppm. This, together with the constant metallurgical flux behaviour, is the decisive reason for the consistently good mechanical quality values with high toughness values at low temperatures. Also suitable for sour gas requirements due to low hardness values (max. 240 HV10). Boniszewski: ~1,7 Powder bulk density: 0.95 kg / dm3 (l) Grain size according to ISO 14174: 2 - 20 (Tyler 8 x 65) Current carrying capacity: up to 1000 A AC or DC with single wire
CLASSIFICATION	EN ISO 14174: SA FB 1 65 AC H5
SUITABLE FOR	S355, S420, S460, S690, P500, P550, X65, X70, X80, Weldox 700, Naxtra 70, Hardox 400, Dilimax, P91, P24 A, B, D, E, A 32-E 36
APPROVALS	No Approvals Found
WELDING POSITIONS	

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

CaF2	CaO+MgO	SiO2+TiO2	Al2O3+MnO
17	30	20	30

REDRYING TEMPERATURE	300°C / 2 hr
GAS ACCORDING EN 14175	