

CEWELD FL 400

TYPE	Agglomerated flux for SAW welding to obtain increased hardness with low and un-alloyed sub arc wires.		
APPLICATIONS	CEWELD® FL 400 is an active SAW flux (C, Cr, Mo alloying characteristic) designed for hard surfacing and joint welding of low alloyed wire electrodes. Reconditioning and hardfacing of parts subject to impact and wear, such as piston rod ends, mining parts, excavator parts, rolling bars, pressure rollers, cement rollers, dredging parts, coupling parts, crushing hammers, etc...		
PROPERTIES	CEWELD® FL 400 is an agglomerated calcium-silicate flux. It exhibits the constant chemical reactions typical of our alloyed fluxes. Basicity according to Boniszewski: ~1.7 Flux density: 1.2–1.3 kg/dm3 (l) Grain size acc. to ISO 14174: 2–16 (Tyler 10×65) Current-carrying capacity: up to 800 A DC using one wire 4.0 mm		
CLASSIFICATION	EN ISO	14174: SA CS 3 99 CCrMo AC	
SUITABLE FOR	Piston rod ends, mining parts, excavator parts, rolling bars, pressure rolls, cement rollers, dredging parts, coupling parts, crushing hammers. etc..		
APPROVALS			
WELDING POSITIONS	 PA  PB  PC		
TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)	CaF2	CaO+MgO	SiO2+TiO2+Al2O3
	10	25	55
MECHANICAL PROPERTIES			
REDRYING	Not required		
GAS ACC. EN ISO 14175			

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FL 400 0,4-1,8MM

Packaging	KG/unit	EanCode
Bag	25	8720663404961