CEWELD®

FL 400

CATEGORY	SAW Arc Submerged
TYPE	Agglomerated flux for SAW welding to obtain increased hardness with low and un-alloyed sub arc wires.
APPLICATIONS	Rebuilding and hardfacing parts that suffer from impact and wear as in Mining, Dredging etc.
PROPERTIES	Aglomerated flux for submerged arc welding with excelent welding properties, this flux is adding several elements to the weldpool to obtaine a hardnes increase with ordinary un- or low alloyed submerged arc wires. The alloying effect is for a great part depending on the parameters beijng used, optimum parameters are 600 Ampere with 32 Volt and 50 cm/min. travel speed. Suitable for single and multi layer welding.

Basicity according to Boniszewski:	DIN EN 760	1.1
Grain size according:	EN 760	0.2-2 mm
Density	dm^3	1.2 kg

CLASSIFICATION	EN ISO	14174: S A CS 3 97 AC
	DIN	32522:B CS 3 97 CCrMo AC 8
SUITABLE FOR	Piston rod ends, mining parts, excavator parts, rolling bars, pressure rolls, cement rollers, dredging parts, coupling parts, crushing hammers. etc..	
APPROVALS	CE approved	

WELDING POSITIONS:

COMPOSITION BY WEIGHT %

SiO^2+TiO^2	CaO + MgO	Al^2O^3+MnO	CaF^2
35%	25%	15%	10%

MECHANICAL PROPERTIES

As welded	All weld analysis					Hardness
with wire	C	Si	Mn	Cr	Mo	HB
S1	0.25	0.5	1.7	3.0	0.4	350-400
S2	0.25	0.9	2.0	3.0	0.4	400-500

RECOMENDED WELDING PARAMETERS

Welding Parameters				
D (mm)	Voltage (V)	Current (A)	travel speed (cm/min)	stick out (mm)
4.0	32	600	50	30-40

REDRYING TEMPERATURE	Usually not necessary. (when became wet, 2hr/350°C)
PACKING	plastic bags of 25 kg / 30 kg buckets and 1000 kg big bags.