CEWELD®

FL CS155

CATEGORY	SAW Arc Submerged
TYPE	Fused flux with very low hydrogen content for SAW welding.
APPLICATIONS	Boiler works, pipes, ship building, structural steel works, tanks and pressure vessels, offshore applications etc..
PROPERTIES	Glassy melted low- manganese flux. Suitable for direct- and alternating current welding at high current up to ca 900 Ampere per wire. The flux causes slight increase of manganese and silicon in the weld, not changing Mn/Si ratio, which ensures high toughness properties of the weld metal and enables to weld plates of unlimited thickness. **Basicity:** 1,05 (according to boniszewski) **Grain size:** 0,32÷1,6 mm **Density:** 1,4÷1,7 kg/dm^3
CLASSIFICATION	EN ISO 14174: SF CS 1 56 AC H5
SUITABLE FOR	Unalloyed steels: St 33 – St 52, Ship building: A, E, AH, EH , Boiler steels: HI-HIII, 17Mn4, 19Mn5, Pipe steels: St 37.0/4 – St 52.0/4, Fine-grain steels:StE 255 – StE 420, X70
APPROVALS	CE approved
WELDING POSITIONS:	

COMPOSITION BY WEIGHT %

CaO + MgO + SiO2	CaO + MgO
>55%	>15%

MECHANICAL PROPERTIES

As welded with wire	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C	Hardness HRc / HV
S2(Si)	>420	>500	32	120			
S3Si	>450	>530	32		>47		
SACW 500	>460	>550	29		>100		

REDRYING TEMPERATURE	Usually not necessary. (when became wet, 2hr/200°C)
PACKING	In paper / plastic bags of 25 kg / 30 kg buckets and 1000 kg big bags.