



CEWELD FL 860 ESHC

TYPE High basic agglomerated flux for welding Nickel based strips with the electro slag process.

APPLICATIONS Designed for ES strip cladding in offshore, apparatus, vessel, boilers and chemical industry.

PROPERTIES FL 860 ESHC is a highly basic flux for Nickel based strip electro slag cladding. Basicity: about 4,2 (according to Boniszewski) Current: DC + Grain size: 2-16

CLASSIFICATION EN ISO 14174: ES A FB 2B 5644 DC

SUITABLE FOR Electro slag cladding with nickel based strip, Inconel 600, 625, 825, alloy 82 and 625, W.Nr: 2.4806, 2.4831, 2.4633, 2.4649, Nicrofer 6025HT, Alloy 602 CA.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)

CaF2	SiO2	CaO+MgO
70	20	5

MECHANICAL PROPERTIES

REDRYING Not required

GAS ACC. EN ISO 14175



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FL 860 ESHC 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	25	8720663404213