



CEWELD FL 180

TYPE Agglomerated rutile flux additive in Mn and Si, suitable for carbon steel welding with two or three passes.

APPLICATIONS Light boiler works, beams, pipes, ship building, structural steel works, small tanks and gas cylinders etc..

PROPERTIES FL 180 is an agglomerated rutile flux with Mn and Si pick-up, suitable for carbon steel welding with two or three passes. Basicity: about 0,4 (according to Boniszewski) Current: DC or AC, in single or multi-wires Grain size: 2-20

CLASSIFICATION EN ISO 14174: SA AR 1 76 AC H5

SUITABLE FOR **S2Mo:** EN: 16Mo3, S(P)355-S(P)420, L245-L450 / ASME: API 5L Grades A, B, X42, X46, X52, X56
S1: EN: S(P)235-S(P)355; L245-L360 / ASME: ASTM A131 Grades A, B, D, DS; A253 all Grades; A529 Grades 42, 50; A570 all Grades; A572 Grades 42, 50; A709 Grades 36, 50
S2: EN: S(P)235-S(P)355; L245-L360 / ASME: ASTM A131 Grades A, B, D, DS; A253 all Grades; A529 Grades 42, 50; A570 all Grades; A572 Grades 42, 50; A709 Grades 36, 50

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)	Al2O3	CaF2	SiO2	CaO+MgO
	55	10	25	5

MECHANICAL PROPERTIES

REDRYING 350°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD FL 180

FL 180 0,2 - 1,6MM

Packaging	KG/unit	EanCode
Bag	27,5	8720663403964

FL 180 0,2 - 2,0MM

Packaging	KG/unit	EanCode
Bag	25	8720663403971