



# CEWELD FL 880

**TYPE** Fused flux for SAW welding stainless steels and Nickel based alloys.

**APPLICATIONS** CEWELD® FL 880 is also suitable for **welding both low alloy steels** for use at elevated temperatures and in combination with austenitic stainless steels.  
It is suitable **for joint welding and surfacing of:**  
**creep resistant CrMo steels for boiler, vessel and pipe fabrication**  
**Martensitic and ferritic Cr(NiMo)** steels with the appropriate wire electrodes and heat treatments  
**Austenitic CrNi(Mo)** steels (including ELC grades) resistant to intergranular corrosion in both as-welded and solution treated condition  
**High alloy CrNi(Mo)** steels for low temperature service and heat resistant steels  
**High-alloy Cr(NiMo)** steels in combination with low-alloy steels (dissimilar joints)  
**Nickel base alloys** using NiCr and NiCrMo wire electrodes.

**PROPERTIES** CEWELD® FL 880 is a **specially designed glassy fused** welding flux for austenitic stainless steels. As a result of the **semi-basic flux** characteristics, **crack free** welds can be achieved on most stainless steel grades when welded with the appropriate wire electrodes. The metallurgical behaviour of the flux is neutral (**C neutral, low Si pick-up and low Mn burn-out**) without Cr compensation.  
It is suitable for DC single or DC/AC multi-wire welding and produces smooth, slag free weld beads with flat weld interfaces even in narrow gaps and on preheated workpieces.  
**Basicity according to Boniszewski:** ~1,3  
**Flux density:** 1.5 kg / dm<sup>3</sup> (l)  
**Grain size acc. to ISO 14174:** 1 – 16  
**Current-carrying capacity:** up to **900 A DC** using one wire or **DC/AC multi-wire**

**CLASSIFICATION** EN ISO 14174: SF CS 2 5742 DC

**SUITABLE FOR** S355, S420, S460, S690, P500, P550, X65, X70, X80, Weldox 700, Naxtra 70, Hardox 400, Dilimax, P91, P24

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL COMPOSITION IN WEIGHT (%)**

Al <sub>2</sub> O <sub>3</sub>	CaF <sub>2</sub>	SiO <sub>2</sub>	CaO+MgO
5	20	30	35

**MECHANICAL PROPERTIES**

**REDRYING** Not required

**WIRE & FLUX COMBINATION** Typical wire combinations: CEWELD® S2Mo ISO 14171-A: S 46 2 AR S2Mo AWS 5.17\_5.23: EA2  
CEWELD® S2CrMo1 ISO 24598-A: S CrMo1 AWS 5.17\_5.23: EB2(R) CEWELD® S2CrMo2 24598-A: S Z CrMo2Mn AWS 5.17\_5.23:EB3 CEWELD® S2CrMo5 ISO 24598-A: S CrMo5 AWS 5.17\_5.23: EB6  
CEWELD® SA 80S-B8 ISO 24598-A: S CrMo9 AWS 5.17\_5.23: EB8 CEWELD® SA 90S-B9 ISO 24598-A: S CrMo91 AR AWS 5.17\_5.23: EB91 CEWELD®SA 307 ISO 14343-A: ~S 18 8 Mn AWS 5.9: ER307  
CEWELD®SA 308L ISO 14343-A: ~S 19 9 L AWS 5.9: ER308L CEWELD®SA 309L ISO 14343-A: ~S 23 12 L AWS 5.9: ER309L CEWELD®SA 309LMO ISO 14343-A: ~S 23 12 3 L AWS 5.9: ~ER309LMO  
CEWELD®SA 310 ISO 14343-A: S 25 20 AWS 5.9: ER310 CEWELD®SA 316L ISO 14343-A: S 19 12 3 L AWS 5.9: ER316L CEWELD®SA 317L ISO 14343-A: S 18 15 3 L AWS 5.9: ER317L CEWELD®SA 318 ISO 14343-A: S 12 12 3 Nb AWS 5.9: ER318 CEWELD®SA 347 ISO 14343-A: S 19 9 Nb AWS 5.9: ER347 CEWELD®SA 2209 ISO 14343-A: S 22 9 3 N L AWS 5.9: ER2209 CEWELD®SA 904L ISO 14343-A: S 20 25 5Cu L AWS 5.9: ER385 CEWELD®SA 2594 ISO 14343-A: 25 9 4 N L AWS 5.9: ER2594  
CEWELD®SA Nicro 600 ISO 18274-A: S Ni 6082 (NiCr20Mn3Nb) AWS 5.14: ERNiCr-3 CEWELD®SA Nicro 625 ISO 18274-A: S Ni 6625 (NiCr22Mo9Nb) AWS 5.14: ERNiCrMo-3 CEWELD®SA Alloy 825 ISO 18274-A: S Ni8065 (NiFe30Cr21Mo3) AWS 5.14: ERNiFeCr-1 CEWELD®SA Alloy C-276 ISO 18274-A: S Ni 6276 (NiCr15Mo16Fe6W4) AWS 5.14: ERNiCrMo-4

**GAS ACC. EN ISO 14175**



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FL 880 0,1 - 1,6MM

Packaging	KG/unit	EanCode
Bag	15/25	8720663404114