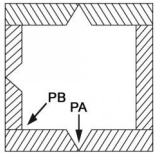


FW CS 1 63 DC 15kg

097-004848-00015



- Molten neutral welding flux
- Suitable for high-alloy stainless steels, Ni-based alloys and low-alloy steels
- Especially crack-resistant in connection with similar or over-alloyed wire electrodes (solid or flux cored wire)

Standards	DIN EN ISO 14174-A (stainless steels) , SF CS 2 DC DIN EN ISO 14174-A (non-/low-alloy steels) , SF CS 163 DC
Welding positions	PA / PB
Polarity	DC+
Baking	In dry rooms, welding flux in original packaging can be stored for up to 3 years from the delivery date. Moist welding flux is to be dried at an effective powder t.e of 200 ± 50 °C.
Welding current	DC+ , 900 A
Approvals	TÜV: SMA 316L
Packing drum	Sack, 15 kg
Grain size	DIN EN ISO 14174-A , 1 - 16
Materials	Creep-resistant CrMo steels such as 12 CrMo 19 5/A378 gr. 5 or X 20 CrMoWV 12 1/A351 for boiler, container and pipe construction , Martensitic (soft martensite) and ferritic Cr(NiMo) steels in acc. w. DIN EN 10088 and austenitic CrNi(Mo) steels in acc. w. DIN EN 10088 , Low-t.e tough and heat-resisting high-alloy CrNi(Mo) steels, dissimilar joints and nickel-base alloys