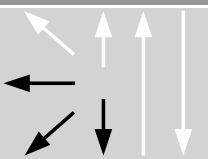


Classifications								
SAW solid wire			SAW flux					
EN ISO14171-A	EN ISO14171-B	AWS A5.23	EN ISO 14174					
S2Mo	SU2M3	EA2	SA FB 1 65 DC H5					
SAW wire/flux combination								
EN ISO14171-A	EN ISO14171-B	AWS A5.23	AWS A5.23M					
S 46 4 FB S2Mo	S55A4 FB SU2M3	F8A4-EA2-A2/F8P0-EA2-A2	F55A4-EA2-A2/F55P2-EA2-A2					
Characteristics and typical fields of application								
<p>Sub arc wire/flux combination suited for fine-grained constructional steels of increased strength and for 0.5% Mo alloyed boiler, plate and tube steels. Approved in long-term condition up to +550°C service temperature. The metallurgical behaviour of the flux BOEHLER BB 24 is neutral. The sub-arc wire/flux combination produces very good low temperature impact properties down to -40°C. Excellent slag detachability, smooth beads, good wetting and low hydrogen contents (≤5 ml/100 g) are further important features. The combination is ideally suited for multipass welding of thick plates. For information regarding the sub-arc welding flux BÖHLER BB 24 see our detailed data sheet.</p>								
Base materials								
<p>Creep resistant steels and similar alloyed cast steels, ageing resistant and steels resistant to caustic cracking, creep resistant constructional steels with comparable yield strength. 16Mo3, S275JR, S275J2G3, S355J2G3, P275T1-P355T1, P275T2-P355T2, P255G1TH, S255N, P295GH, P310GH, P315N-P420N, P315NH-P420NH, BHW 2.5, WB 25 ASTM A335 Gr. P1; A161-94 Gr. T1; A182M Gr. F1, A204M Gr. A, B, C; A250M Gr. T1; A217 Gr. WC1, API 5L X52-X65</p>								
Typical analysis of the wire and of all-weld metal (wt.-%)								
	C	Si	Mn	Mo	P	As	Sb	Sn
SAW wire wt.-%	0.1	0.12	1.0	0.5				
all-weld metal %	0.07	0.25	1.15	0.5	≤ 0.012	≤ 0.01	≤ 0.005	≤ 0.005
Mechanical properties of all-weld metal								
Condition	Yield strength	Tensile strength	Elongation	Impact work				
	R _{p0,2}	R _m	A (L ₀ =5d ₀)	ISO-V KV J				
	MPa	MPa	%	+20 °C	-20 °C	-40 °C		
u	540 (≥ 460)	630 (550 – 680)	25 (≥ 20)	140	80	≥ 47		
s	≥ 460	550 – 680	≥ 17	≥ 47	≥ 27			
n+a	≥ 280	≥ 440	≥ 26	≥ 125				
u	untreated, as-welded							
s	stress relieved, 580- 620°C/2h/ furnace down to 300°C/air							
n+a	normalised 920 °C and annealed 620 °C							

Operating data			
	Polarity: DC (+)	Redrying of sub-arc flux: 300 – 350 °C, 2 – 10 h	ø (mm) 2.0 2.5 3.0 4.0
	Preheating, interpass temperature and post weld heat treatment are determined by the base metal.		
Approvals			
Wire/flux combination : TÜV (7810.), NAKS Wire: TÜV (02603.), KTA 1408.1 (08058./08060.), DB (52.014.06), SEPROZ, CE			