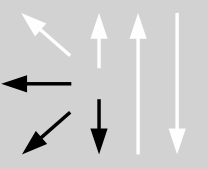


Classifications						
SAW solid wire				SAW flux:		
EN ISO 14343-A		AWS A5.9		EN ISO 14174		
S 19 9 L		ER308L		SA FB 2 DC		
Characteristics and typical fields of application						
<p>BÖHLER EAS 2-UP (LF) / BB 203 is a wire-flux combination for submerged arc welding of stainless steel grades like 1.4306 / 304L.</p> <p>The wire composition has been optimised in its chemical composition to provide a slightly lower ferrite content, compared to a standard ER 308L wire, to get higher impact strength at -196 °C in the weld metal. Applications can be found in multiple cryogenic applications like LNG.</p> <p>BB 203 is an agglomerated basic flux with relative high basicity index, however with good welding properties with nice bead appearance and good slag detachability. For more information regarding this sub-arc welding flux see our detailed data sheet.</p>						
Base materials						
1.4306 – X2CrNi19-11, 1.4301 – X5CrNi18-10, 1.4311 – X2CrNi18-10, 1.4312 – GX10CrNi18-8, 1.4541 – X6CrNiTi18-10, 1.4546 – X5CrNiNb18-10 1.4550 – X6CrNiNb18-10 AISI 304, 304L, 304LN, 302, 321, 347; ASTM A157 Gr. C9, A320 Gr. B,C or D						
Typical analysis of the wire and of all-weld metal (wt.-%)						
	C	Si	Mn	Cr	Ni	FN (WRC)
Wire	≤ 0.025	0.50	1.8	20.0	9.8	3-8
Weld metal	≤ 0.025	0.60	1.5	19.5	9.8	3-8
Mechanical properties of all-weld metal (minimum values)						
Heat-treatment	Yield strength	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact work ISO-V CVN J		Lateral expansion
	$R_{p0,2}$	MPa	%	+20 °C	-196 °C	
aw	>320	>550	>30	>65	>40	> 0.38
Operating data						
		Polarity: DC +				
Approvals						
-						