

Standards

TS EN ISO 14174	: SA AB 1 68 AC H5
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AWS A5.17	: F6A2-EL12 / F7A4-EM12 / F7A2-EM12K / F7A4-EH12K
AWS A5.23	: F8A4-EA2-A2

Basicity 1.4

Mechanical Properties

SAW Wire	AWS A5.17 / AWS A5.23	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)		
					-20°C	-30°C	-40°C
S1	F6A2-EL12	380	480	28	55	47	---
S2	F7A4-EM 12	460	525	30	70	55	50
S2 Si	F7A2-EM12K	430	530	28	80	70	---
S3 Si	F7A4-EH12K	460	550	27	---	---	60
S2 Mo	F8A4-EA2-A2	490	600	26	90	---	60

Chemical Composition of Weld Metal - % (Typical)

SAW Wire	C	Si	Mn	Mo
S1	0.06	0.25	1.20	---
S2	0.07	0.35	1.50	---
S2 Si	0.05	0.40	1.70	---
S3 Si	0.07	0.40	1.80	---
S2 Mo	0.06	0.40	1.40	0.50

Features and Applications

- A type of submerged welding (SAW) basic flux structured from agglomerated aluminate.
- Applicability in single-and multi-pass (butt-) joint welding and fillet welding of general-purpose construction steels, shipbuilding steel, boiler sheet, heat-resisting steels, and fine-grained steels.
- Low consumption of flux.
- Basicity: 1.4
- High toughness of weld metal at low temperatures.
- Formation of easily-removed slag.
- Requirement of re-drying at 300°C - 350°C for 2 hours.

Operating Data

Product Code	Package Weight (Kg)	Package Type
301080002	25	Kraft Bag

Approvals: ELIFLUX BFB: CE, GOST-R, SEPPO • **S2Si x ELIFLUX BFB:** ABS, LR, CE

S2 x ELIFLUX BFB: TL, DNV-GL, BV, ABS, LR, RS, NK, RINA, DB • **S2Mo x ELIFLUX BFB:** BV, ABS, CE