Standards

TS EN ISO 14174	: SA FB 1 66 AC H5
EN ISO 14174	: SA FB 1 66 AC H5
AWS A5.17	: F7A2-EM12/F7A2-EM12K
AWS A5.23	: F8A4-EA2-A2/F8A5-EA4-A3/ F11A8-EM4(mod)-M4

Basicity
2.8

Mechanical Properties

SAW Wire	AWS A5.17 AWS A5.23	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation ((Lo=5do) (%)	Impact Strength ISO-V(J)			
					-30°C	-40°C	-50°C	-60°C
S2	F7A2-EM12	430	520	29	60	---	---	---
S2 Si	F7A2-EM12K	440	515	30	65	---	---	---
S2 Mo	F8A4-EA2-A2	490	595	26	---	60	---	---
S3Si	F8A5-EA4-A3	500	588	27	---	100	80	---
S3NiCrMo2.5	F11A8-EM4(mod.)-M4	700	775	23	---	55	45	min.27

Chemical Compositon of Weld Metal - % (Typical)

Saw Wire	C	Si	Mn	Mo	Cr	Ni
S2	0.06	0.35	1.20	---	---	---
S2 Si	0.07	0.40	1.25	---	---	---
S2 Mo	0.07	0.40	1.30	0.50	---	---
S3 Mo	0.05	0.30	1.75	0.50	---	---
S3 NiCrMo 2.5	0.06	0.40	1.75	0.50	0.40	2.10

Features and Applications

- GeKa ELIFLUX BFPV, high basic, is agglomerated fluoride basic flux for submerged arc welding.
- It features high impact toughness and low hydrogen content
- It is suitable for double wire welding and narrow gap welding of thick steel plates, pressure vessels
- Flux should be re-dried before use for 2 hours at 300°C - 350°C

Operating Data

Product Code	Package Weight (Kg)	Package Type
6010800016	25	Kraft Bag

Approvals: SEPRO, GOST-R