

Standards

EN ISO 14171-A	: S 46 6 FB T3 H5
AWS A5.17	: F7A8-EC1 / F7P8-EC1

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo
0.04	0.25	1.65	0.4

Mechanical Properties

As Welded	AWS A5.17	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)	
					-40°C	-60°C
SR 1h/620°C	F7A2-EM12K F7P2-EM12K	>470	550-700	>22	>100	>80

Typical Base Material Grades

- Ship: Building: ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C
S355JR, S355JO, S355J2, S460N, S460M, S275NL-S460NL, S275ML-S460ML
P460GH, P460NL1, P275NL2-P460NL2, P215NL, P265NL, P355N, P285NH-P355NH
(H1, H11, 17Mn4, 19Mn5, 15Mo3, 16Mo3)
API 5 L Gr. B, X42, X52, X56, X60, X65
A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70

Features and Applications

- SAWCOR B-35 is a seamless copper coated basic flux cored wire for SAW with an excellent quality of the joint and meets the highest requirements. Used for the welding of structural and fine grain steels in combination with fluxes ELIFLUX BFF 30 ELIFLUX BFF 55, ELIFLUX BFF 65
- Welding with this wire enables up to 30% more cost-effective production compared to solid wire of the same diameter.
- The wire is used with success in applications such as offshore wind energy, platforms, shipbuilding, steel and apparatus construction, mechanical engineering and pipe work.
- It is very suitable for multi-layer welding (wall thickness unlimited), two-run technique up to 20mm and single-pass joint (one side welding on back up).
- SAWCOR B-35 is extremely crack resistant weld metal conditioned by the basic slag in combination with very low hydrogen content and does not moisture pick up. It can be stored indefinitely.

Operating Data

Diameter (mm) / (inch)	Weight (Kg)	Package Type
2.4	25	K 435
4.0	25	K 435