

Standards

ISO 14174	: S A FB 1 55 AC H5
EN 760	: S A FB 1 55 AC
AWS A5.17	: F7A8/P8-EM12(K)
AWS A5.17	: F8A8/F7P8-EH12K

Basicity ~3.2

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	-60°C
S2	EM12(K)	>400	>490	>26	>100	---	>70	>47
S2 Mo	EA2	>490	>570	>23	>90	---	>47	---
S3 Si	EH12K	>470	>560	>25	>100	---	>80	>47
S3 NiMo1	EF3	>570	>670	>22	>110	---	>80	>47
S3NiCrMo2.5	EM4mod.	>690	>820	>18	>90	---	>70	>47

Chemical Composition of Weld Metal - % (Typical)

Saw Wire	C	Si	Mn	Mo	Ni	Cr
S2	0.07	0.2	1.0	---	---	---
S2 Mo	0.07	0.2	1.1	0.5	---	---
S3 Si	0.07	0.4	1.4	---	---	---
S3 NiMo 1	0.08	0.2	1.4	0.5	1.0	---
S3 NiCrMo 2.5	0.08	0.2	1.5	0.5	2.5	0.5

Features and Applications

- ELIFLUX BFF 30 is a fluoride-basic neutral flux with high basicity and low impurity levels such as P and S.
- As a result of low oxygen levels in the weld deposits uniform mechanical properties with high toughness values at low temperature are achieved.
- Designed for multi wire application where high deposition rate as well as good slag removal is required this flux shows excellent weldability and weld bead appearance.
- ELIFLUX BFF 30 is suitable for welding on D.C. and A.C. using single, tandem and Multi-Wire processes.
- Process requirement of re-drying at 300°C - 350°C for 2 hours

Operating Data

Package Weight (Kg)	Package Type
25	Vacum pack