Standards

TS EN ISO 14174	: SA FB 1 65 DC H5
EN ISO14174	: SA FB 1 65 DC H5
AWS A5.17	: F7A4-EM12/F7A4-EM12K/ F7A4-EH12K
AWS A5.23	: F8A4-EA2-A2/ F9A4-EF3(mod)-F3 / F11A8-EM4(mod)-M4

Basicity
3.0

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	F7A4-EM12	410	520	24	---	70	60	---
S2 Si	F7A4-EM12K	450	540	23	---	---	65	---
S2 Mo	F8A4-EA2-A2	480	570	27	---	---	70	---
S3 Si	F7A4-EH12K	490	580	26	---	---	60	---
S3 NiMo1	F9A4-EF3(mod)-F3	580	650	21	100	---	60	---
S3NiCrMo2.5	F11A8-EM4(mod.)-M4	740	850	20	90	---	85	min.27

Chemical Compositon of Weld Metal - % (Typical)

Saw Wire	C	Si	Mn	Mo	Ni	Cr
S2	0.05	0.20	1.00	---	---	---
S2 Si	0.06	0.30	1.10	---	---	---
S2 Mo	0.07	0.25	1.15	0.45	---	---
S3 Si	0.10	0.60	1.70	---	---	---
S3 NiMo 1	0.09	0.25	1.65	0.55	0.90	---
S3 NiCrMo 2.5	0.06	0.30	1.50	0.50	2.20	0.50

Features and Applications

- This is fluoride-basic agglomerated flux
- This flux is suitable for welding high strength low alloy steels
- Prefable to use with wire electrodes having higher manganese level
- Recommended for multi-pass welding, in particular when there are high toughness requirement
- Process requirement of re-drying at 300°C - 350°C for 2 hours

Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800012	25	Kraft Bag

Approvals: **ELIFLUX BFF:** CE, SEPRO • **S2Si x ELIFLUX BFF:** BV, ABS, CE
S3Si x ELIFLUX BFF: BV,ABS, CE • **S2Mo x ELIFLUX BFF:** DNV-GL, BV, ABS, CE
S3NiCrMo2.5 x ELIFLUX BFF: ABS, CE