

Standards

TS EN ISO 14174	: SA AB 1 66 AC H5
EN ISO 14174	: SA AB 1 66 AC H5
AWS A5.17	: F7A2-EM12/F7A2-EM12K
AWS A5.23	: F8A4-EA2-A2

Basicity 1.6

Mechanical Properties

SAW Wire	AWSA5.17 AWSA5.23	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (Lo=5do) (%)	Impact Strength ISO-V(J)	
					-30°C	-40°C
S2	F7A2-EM 12	430	520	29	60	---
S2 Si	F7A2 EM12K	440	515	30	65	---
S2 Mo	F8A4-EA2-A2	490	595	26	---	60

Chemical Composition of Weld Metal - % (Typical)

SAW Wire	C	Si	Mn	Mo
S2	0.06	0.35	1.20	---
S2Si	0.07	0.40	1.25	---
S2 Mo	0.07	0.40	1.30	0.50

Features and Applications

- GeKa ELIFLUX BFPP, is agglomerated aluminate 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 and spiral welded pipes
- With suitable wires, also can be used for welding of 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
6010800015	25	Kraft Bag

Approvals: SEPRO, CE