

## Standards

TS EN ISO 14174	: SA FB 2 65 DC
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Basicity
2.45

## Mechanical Properties

SAW Wire	Standards	Tensile Strength (N/mm <sup>2</sup> )	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)		
				0°C	-110°C	-196°C
ELOX UP 307	ER 307	---	---	---	---	---
ELOX UP 308L	ER 308 L	550	41	70	50	58 J
ELOX UP 309L	ER 309 L	540	35	---	---	---
ELOX UP 316 L	ER 316 L	570	39	60	50	35 J

## Chemical Composition of Weld Metal - % (Typical)

Saw Wire	C	Si	Mn	Mo	Cr	Ni	P	S
ELOX UP 307	---	---	---	---	---	---	---	---
ELOX UP 308 L	0.03	0.54	1.57		19.20	9.30	0.018	0.009
ELOX UP 309 L	0.03	0.40	1.63	0.03	24.20	13.10	0.017	0.008
ELOX UP 316 L	0.03	0.40	1.73	2.13	19.00	11.20	0.025	0.008

## Features and Applications

- A type of fluoride basic flux for SAW
- General use in submerged welding of stainless steel materials
- Very high corrosion resistance
- Very good mechanical properties
- Formation of easily-removable slags
- Requirement of re-drying at 300-350°C for 2 hours

## Operating Data

Product Code	Package Weight (Kg)	Package Type
6010800014	25	Kraft Bag

Approvals: CE, SEPRO