

## Standards

TS EN ISO 14171-A	: S1
EN ISO 14171-A	: S1
AWS A5.17	: EL 12

## Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cu
0.08	0.10	0.50	<0.30 <sup>1</sup>

<sup>1</sup>:copper-plated

## Mechanical Properties

Submerged Arc Flux	AWS A5.17	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)		
					0°C	-20°C	-30°C
ELIFLUX BAR	F6 AZ-EL 12	360	460	26	47	---	---
ELIFLUX BFB	F6 A2-EL 12	380	480	28	---	55	47
ELIFLUX BMS	F6 AZ-EL 12	395	475	24	38	---	---
ELIFLUX BBR-AG	F6 A0-EL 12	370	480	30	60	50	---

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

Submerged Arc Flux	C	Si	Mn
ELIFLUX BAR	0.07	0.50	1.10
ELIFLUX BFB	0.06	0.25	1.20
ELIFLUX BMS	0.05	0.80	1.10
ELIFLUX BBR-AG	0.06	0.30	0.90

## Typical Base Material Grades

- Structural Steels: S185-S235JR
- Pipe Steels: S275N
- Boiler Steels: P235GH
- Ship-Construction Steels: A, B, D
- Fine-grained Steels: P275N, S355N

## Features and Applications

- Copper-coated wire.
- Applicability in welding of steel constructions, pipes and tanks as well as in submerged arc welding of unalloyed structural steels and plates.

## Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010400000	1.6	1/16	25	K 435 *BIG PACK
3010400001	2.0	5/64	25	
3010400002	2.4	3/32	25	
3010400003	3.2	1/8	25	
3010400004	4.0	5/32	25	
3010400005	5.0	3/16	25	

\* Packaging alternatives according to the order; 30 - 350 - 550 - 1000 Kg

**Approvals:** S1 x ELIFLUX BAR · BV, DNV-GL, TL, ABS, LR, CE, SEPRO

S1: TSE, CE SEPRO