

Standards

TS EN ISO 14171-A	: S2
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AWS A5.17	: EM 12

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cu
0.12	0.10	1.0	<0.30 ¹

¹:copper-plated

Mechanical Properties

Submerged Arc Flux	AWS A5.17	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)			
					0°C	-20°C	-30°C	-40°C
ELIFLUX BAR	F6 AZ-EM 12 F6 PZ-EM 12	400	500	30	60	---	---	---
ELIFLUX BFB	F7 A4-EM 12	460	525	30	---	70	55	50
ELIFLUX BFF	F7 A4-EM 12	410	520	24	---	---	70	60
ELIFLUX BBR-AG	F7 A2 EM12	410	490	32	50	50	50	---
ELIFLUX BMS	F6 A0-EM 12	390	485	30	---	69	---	---
ELIFLUX PIPE	F7 A4-EM 12	460	550	26	---	75	---	50
ELIFLUX BAB-S	F7 A4-EM 12	430	525	29	---	---	---	60 J

Chemical Composition of Weld Metal - % (Typical)

Submerged Arc Flux	C	Si	Mn
ELIFLUX BAR	0.07	0.60	1.35
ELIFLUX BFB	0.07	0.35	1.50
ELIFLUX BFF	0.05	0.20	1.00
ELIFLUX BBR-AG	0.10	0.35	1.20
ELIFLUX BMS	0.04	0.45	1.27
ELIFLUX PIPE	0.07	0.40	1.35

Typical Base Material Grades

- Structural Steels: S355JR
- Pipe Steels: L360
- Boiler Steels: P295GH, P 355 GH
- Ship-Construction Steels: A, B, D, E
- Fine-grained steels: P355N, S355N

Features and Applications

- Applicability in welding of steel construction, pipe manufacturing, pressure vessels, structural steels and ship plates, general structural steels with tensile strength up to 500 N/mm² and unalloyed or medium strength steel

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010400033	1.6	1/16	25	K 435 *BIG PACK
3010400034	2.0	5/64	25	
3010400035	2.4	3/32	25	
3010400036	3.2	1/8	25	
3010400037	4.0	5/32	25	
3010400038	5.0	3/16	25	

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

Approvals: S2: CE, TSE, DB, SEPRO • S2 x ELIFLUX BAR: BV, ABS, CE, DB, SEPRO • S2 x ELIFLUX BAB-S: ABS, CE, SEPRO
S2 x ELIFLUX BFB: TL, DNV-GL, BV, ABS, LR, RS, NK, RINA, TÜV, CE, DB, SEPRO
S2 x ELIFLUX BMS: BV, ABS, CE