

### Standards

TS EN ISO 14171-A	: S2 Mo
EN ISO 14171-A	: S2 Mo
AWS A5.23	: EA2

### Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo	Cu
0.12	0.10	1.0	0.5	<0.30 <sup>1</sup>

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

### Mechanical Properties

Submerged Arc Flux	AWS A5.23	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation ((Lo=5do) (%)	Impact Strength ISO-V(J)	
					-20°C	-40°C
ELIFLUX BFB	F8A4-EA2-A2	490	600	26	90	60
ELIFLUX BFF	F8A4-EA2-A2 F8P5-EA2-A2	480	570	27	---	70
ELIFLUX BAB-S	F8A4-EA2-A3	500	600	26	---	60
ELIFLUX PIPE	F7 A4-EA2-A4	510	640	25	---	60

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

Submerged Arc Flux	C	Si	Mn	Mo
ELIFLUX BFB	0.06	0.40	1.40	0.50
ELIFLUX BFF	0.07	0.25	1.15	0.45
ELIFLUX BAB-S	0.07	0.55	1.70	0.50
ELIFLUX PIPE	0.06	0.40	1.40	0.50

### Typical Base Material Grades

- Pipe Steels: L485MB(X70)
- Boiler Steels: 16Mo3, P355 GH
- Fine-grained Steels: S460N, P460N

### Features and Applications

- Specific applicability in welding high-strength low-alloyed steels and creep-resisting steels
- Weld metal of 1/2 Mo-alloy with resistance to creep at high-temperature applications
- Serviceability at temperatures of values up to 500°C

### Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010400140	2.0	5/64	25	K 435 *BIG PACK  <small>* Packaging alternatives according to the order; 30 - 350 - 550 - 1000 Kg</small>
3010400141	2.4	3/32	25	
3010400142	3.2	1/8	25	
3010400143	4.0	5/32	25	
3010400144	5.0	3/16	25	

**Approvals:** S2Mo x ELIFLUX BFB: BV, ABS, CE • S2Mo: TSE, CE, DB, SEPPO  
S2Mo x ELIFLUX BFF: DNV-GL, BV, ABS, CE • S2Mo x ELIFLUX BAB-S: ABS, CE