

**Standards**

TS EN ISO 14171-A	: S3 Si
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AWS A5.17	: EH 12 K

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

C	Si	Mn	Cu
0.10	0.30	1.70 - 1.80	<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 ((L <sub>0</sub> =5d <sub>0</sub> ) (%))	Impact Strength ISO-V(J)	
					0°C	-40°C
ELIFLUX BFF	F7A4-EH 12K	490	580	26	100	70
ELIFLUX BFB	F7A4-EH 12K	460	550	27	---	60
ELIFLUX BAB-S	F7A4-EH 12K	545	645	26	---	60

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

Submerged Arc Flux	C	Si	Mn
ELIFLUX BFF	0.10	0.35	1.65
ELIFLUX BFB	0.07	0.40	1.80
ELIFLUX BAB-S	0.07	0.60	1.70

**Typical Base Material Grades**

- Fine-grained Steels: S460N, P460N

**Features and Applications**

- Inclusion of high contents of Mn-Si alloy
- Applicability in submerged arc welding processes of medium- and high-strength structural steels and of steels in offshore structures

**Operating Data**

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010400110	2.0	5/64	25	K 435 *BIG PACK  <small>* Packaging alternatives according to the order; 30 - 350 - 550 - 1000 Kg</small>
3010400111	2.4	3/32	25	
3010400112	3.2	1/8	25	
3010400113	4.0	5/32	25	
3010400114	5.0	3/16	25	

**Approvals:** S3 Si x ELIFLUX BFF: BV, ABS, CE • S3 Si: CE, TSE, SEPRO • S3 Si x ELIFLUX BAB-S: ABS, CE