

Standards

TS EN ISO 14171-A	: S3 Mo
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AWS A5.23	: EA4

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo	Cu
0.10	0.15	1.50	0.50	<0.30 ¹

¹:copper-plated

Mechanical Properties

Submerged Arc Flux	AWSA5.23	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%)	Impact Strength ISO-V(J)	
					0°C	-40°C
ELIFLUX BFF	F8 A4-EA4-A4	540	630	27	110	65
ELIFLUX PIPE	F8 A4-EA4-A4	530	620	25	100	50

Chemical Composition of Weld Metal - % (Typical)

Submerged Arc Flux	C	Si	Mn	Mo
ELIFLUX BFF	0.07	0.50	1.75	0.50
ELIFLUX PIPE	0.06	0.40	1.60	0.45

Typical Base Material Grades

- Fine-grained Steels: S460N, P460N

Features and Applications

- Suitability to high-quality welding of Mo-alloyed steels, boiler sheet steels, and fine-grained steels

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010400176	2.4	3/32	25	K 435
3010400178	4.0	5/32	25	*BIG PACK

Approvals: S3 Mo: TSE, CE, SEPRO

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