

**Mechanical Properties**

Submerged Arc Welding Wire	Submerged Arc Welding Wire Flux	Standards (AWS A5.9)	Tensile Strength (N/mm <sup>2</sup> )	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)		
					0°C	-110°C	-196°C
ELOX UP 307	ELIFLUX BSS-A	ER 307	620	---	---	37	---
ELOX UP 308L	ELIFLUX BSS-A	ER 308L	555	42	72	48	41
ELOX UP 309L	ELIFLUX BSS-A	ER 309L	545	36	---	---	---
ELOX UP 316L	ELIFLUX BSS-A	ER 316L	570	39	63	52	40
ELOX UP 2209	ELIFLUX BSS-D	ER 2209	830	32	---	---	---
ELOX UP 410	ELIFLUX BSS-F	ER 410	530	25	---	---	---
ELOX UP 430	ELIFLUX BSS-F	ER 430	460	20	---	---	---

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

Product	Submerged Arc Welding Wire Flux	C	Si	Mn	Mo	Cr	Ni	P	S
ELOX UP 308L	ELIFLUX BSS-A	0.030	0.53	1.55	---	19.25	9.36	0.015	0.008
ELOX UP 309L	ELIFLUX BSS-A	0.028	0.42	1.65	0.55	24.25	13.16	0.014	0.009
ELOX UP 316L	ELIFLUX BSS-A	0.030	0.40	1.75	2.15	19.10	11.30	0.018	0.010
ELOX UP 2209	ELIFLUX BSS-D	0.030	0.90	1.85	3.15	21.85	8.50	0.018	0.008
ELOX UP 410	ELIFLUX BSS-F	0.110	0.31	0.39	0.13	13.20	0.37	0.028	0.010
ELOX UP 430	ELIFLUX BSS-F	0.040	0.40	0.50	0.20	16.50	0.18	0.020	0.010

**Package Type**

Product	Product Code	Diameter (mm)	Weight (Kg)
ELOX UP 307	6011100384	2.4	25
ELOX UP 308L	6011100299	2.4	25
	6011100091	3.2	25
ELOX UP 309L	6011100300	2.4	25
	6011100301	3.2	25
	6011100302	4.0	25
ELOX UP 316L	6011100303	2.4	25
	6011100096	3.2	25
ELOX UP 2209	6011100306	2.4	25
	6011100307	3.2	25
ELOX UP 410	6011100304	4.0	25
ELOX UP 430	6011100098	3.2	25
	6011100305	4.0	25

**Approvals:** CE, SEPRO  
 GeKa ELOX UP 2209 x ELIFLUX BSS-D: CE, NK