BÖHLER EAS 4 M-UP // BB 202

SAW wire/flux-combination, high-alloyed, stainless

Classifications

SAW solid wire:			Sub-arc flux:
EN ISO 17633-A	**EN ISO 17633-B**	**AWS A5.9**	**EN ISO 14174**
S 19 12 3 L	SS316L	ER316L	SA FB 2 DC

Characteristics and typical fields of application

SAW wire/flux-combination for multi-pass welding of stainless steel grades like 1.4435 / 316L.

Smooth beads, easy slag removal without any slag residues and good welding characteristics even for fillet welds are very much appreciated by users.

Suited for service temperatures from –120 °C to +400 °C.

BÖHLER BB 202 is a fluoride-basic agglomerated flux providing low flux consumption and a low hydrogen weld metal. For information regarding this sub-arc welding flux see our detailed data sheet.

Base materials

1.4401 X5CrNiMo17-12-2, 1.4404 X2CrNiMo17-12-2, 1.4435 X2CrNiMo18-14-3, 1.4436 X3CrNiMo17-13-3, 1.4571 X6CrNiMoTi17-12-2, 1.4580 X6CrNiMoNb17-12-2, 1.4583 X10CrNiMoNb18-12, 1.4409 GX2CrNiMo 19-11-2

UNS S31603, S31653; AISI 316L, 316Ti, 316Cb

Typical analysis of the wire and of all-weld metal (wt.-%)

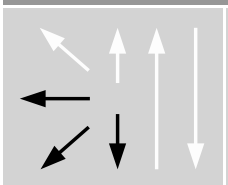
	C	Si	Mn	Cr	Ni	Mo
SAW wire wt.-%	≤ 0.02	0.50	1.7	18.5	12.2	2.8
all-weld metal %	0.02	0.60	1.2	18.0	12.2	2.8

Mechanical properties of all-weld metal

Condition	Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J			
	MPa	MPa	%	+20 °C	–50 °C	–100 °C	–120 °C
u	≥ 320	≥ 510	≥ 25	80	≥ 60	≥ 50	≥ 32

u untreated, as welded

Operating data



Polarity:	**Redrying of sub-arc flux:**	**ø (mm)**
DC (+) / DC (–)	300 – 350 °C, 2 – 10 h	3.0

Approvals

SAW wire/flux combination: TÜV (07508.)

SAW solid wire: TÜV (02604.), DB (52.014.13), SEPROZ, CE