

Classifications

SAW wire:		SAW flux:
EN ISO 18274	AWS A5.14	EN ISO 14174
S Ni 6625 (NiCr22Mo9Nb)	ERNiCrMo-3	SA FB 2 AC

Characteristics and typical fields of application

For SAW wire and flux combination, suitable for welding of the 6 % Mo super-austenitic grades S31254, N 08926, N 08367 and the matching alloy 625 and alloy 825. Weld metal meet highest quality and corrosion requirements. Extremely resistant to stress corrosion cracking and pitting. The pitting resistance equivalent is > 52. BB 444 is an agglomerated fluoride basic welding flux with high basic slag characteristics. For information regarding this sub- arc flux see our detailed data sheet.

Base materials

2.4856 NiCr 22 Mo 9 Nb, 2.4858 NiCr 21 Mo, 2.4816 NiCr 15 Fe, 1.4583 X10CrNiMoNb18-12, 1.4876 X 10 NiCrAlTi 32 20 H, 1.4876 X 10 NiCrAlTi 32 20, 1.4529 X1NiCrMoCuN25-20-7, X 2 CrNiMoCuN 20 18 6, 2.4641 NiCr 21 Mo 6 Cu

Joint welds of listed materials with non-alloy and low alloy steels, e.g P265GH, P285NH, P295GH, 16Mo3, S355N, X8Ni9, ASTM A 553 Gr.1, B443, B446, UNS N06625

N 08926, Alloy 600, Alloy 625, Alloy 800, 9 % Ni-steels

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

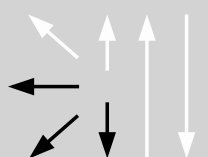
	C	Si	Mn	Cr	Mo	Ni	Nb	Fe
SAW wire wt.-%	0.015	0.15	0.2	22.0	9.0	Bal.	3.6	< 0.5
all-weld metal %	0.020	0.25	0.2	21.5	8.5	Bal.	3.2	< 1.0

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	-196 °C
u	≥ 420	≥ 700	≥ 40	≥ 80	70

u untreated, as welded

Operating data

	Polarity: DC (+) / DC (-) / AC	Redrying of sub arc flux: 400 – 450 °C/2 h	ø (mm) 2.4

Approvals

Wire/flux combination: TÜV (10553.), CE