

## Classifications

SAW solid wire:			Sub arc flux:
<b>EN ISO 14343-A</b>	<b>EN ISO 14343-B</b>	<b>AWS A5.9</b>	<b>EN ISO 14174</b>
S 19 9 Nb	SS347	ER347	SA FB 2 DC

## Characteristics and typical fields of application

SAW wire/flux-combination for multi-pass welding of stainless steel grades like 1.4541 / 347. 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  $-196\text{ °C}$  to  $+400\text{ °C}$ . BÖHLER BB 202 is a fluoride-basic agglomerated flux providing, a low flux consumption and a low hydrogen weld metal. For information regarding this sub-arc welding flux see our detailed data sheet.

## Base materials

1.4550 X6CrNiNb18-10, 1.4541 X6CrNiTi18-10, 1.4552 GX5CrNiNb19-11, 1.4301 X5CrNi18-10, 1.4312 GX10CrNi18-8, 1.4546 X5CrNiNb18-10, 1.4311 X2CrNi18-10, 1.4306 X2CrNi19-11  
AISI 347, 321,302, 304, 304L, 304LN; ASTM A296 Gr. CF 8 C, A157 Gr. C9, A320 Gr. B8C or D

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

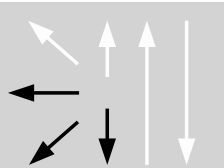
	C	Si	Mn	Cr	Ni	Nb
SAW wire wt-%	0.050	0.50	1.8	19.5	9.5	0.65
all-weld metal %	0.048	0.60	1.3	19.0	9.5	0.55

## Mechanical properties of all-weld metal

Condition	Yield strength	Tensile strength	Elongation	Impact work			
	$R_{p0.2}$	$R_m$	A ( $L_0=5d_0$ )	ISO-V KV J			
	MPa	MPa	%	+20 °C	-50 °C	-100 °C	-196 °C
u	≥ 350	≥ 550	≥ 25	≥ 80	≥ 70	≥ 50	≥ 32

u untreated, as welded

## Operating data

	<b>Polarity:</b> DC (+) / DC (-)	<b>Redrying of sub arc flux:</b> 300 – 350 °C / min. 2 h	<b>ø (mm)</b> 3.0
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## Approvals

TÜV (07510.), TÜV (09172. with BB 203)  
SAW solid wire: TÜV (02604.), DB (52.014.02), SEPPOZ, CE