

Classification

EN ISO 14174

SA FB 2 DC

Characteristics and typical fields of application

BÖHLER BB 202 is an agglomerated fluoride-basic flux for single and multipass welding of Cr-steels and non-stabilised and stabilised austenitic CrNi(Mo)-steels as well as ferritic-austenitic Duplex-steels. The flux BB 202 produces well contoured and smooth welding beads, easy slag removal without any slag residues and good welding characteristics even for fillet welds are very much appreciated by users. It offers an especially low flux consumption. The weld deposits show high purity and good mechanical properties.

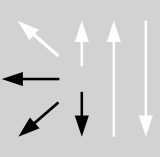
Base materials

Cr-steels and unstabilised or stabilised austenitic CrNi(Mo)-steels as well as austenitic-ferritic duplex steels

Composition of sub-arc welding flux (wt. %)

	SiO ₂	Al ₂ O ₃	CaF ₂
wt.-%	10	38	50

Operating data

	Polarity DC (+) / DC (-)	Basicity acc. to Boniszewski:	2.3 Mol. %
		Bulk density:	1.0 kg / dm ³
		Grain size acc. to EN ISO 14174:	4 – 14 (0.4 – 1.4 mm)
		Flux consumption:	0.7 kg flux per kg wire
		Redrying:	300 – 350°C, 2h

Typical Composition of All-weld Metal with different Wires

SAW wires	C	Si	Mn	Cr	Ni	Mo	Nb	Cu	N
BÖHLER CN 18/11-UP	0,040	0,59	1,3	18,5	9,3				
BÖHLER EAS 2-UP	0,020	0,55	1,3	19,5	9,8				
BÖHLER SAS 2-UP	0,048	0,60	1,3	19,0	9,5		0,55		
BÖHLER EAS 4 M-UP	0,020	0,60	1,2	18,0	12,2	2,8			
BÖHLER SAS 4-UP	0,03	0,60	1,2	18,0	11,4	2,8	0,55		
BÖHLER ASN 5 SY-UP	≤0,03	0,60	1,2	18,5	13,4	3,5			
BÖHLER CN 22/9 N-UP	0,013	0,50	1,1	22,5	8,8	3,2			0,14
BÖHLER CN 23/12-UP	0,015	0,60	1,3	23,5	13,2				

Classification of the wires	EN ISO 14343-A	AWS A5.9
BÖHLER CN 18/11-UP	S 19 9 H	ER19-10H
BÖHLER EAS 2-UP	S 19 9 L	ER308L
BÖHLER SAS 2-UP	S 19 9 Nb	ER347
BÖHLER EAS 4 M-UP	S 19 12 3 L	ER316L
BÖHLER SAS 4-UP	S 19 12 3 Nb	ER318
BÖHLER ASN 5 SY-UP	-	ER317L
BÖHLER CN 22/9 N-UP	S 22 9 3 NL	ER2209
BÖHLER CN 23/12-UP	S 23 12 L	ER309L

Approvals

Approval is available for BÖHLER BB 202 together with BÖHLER-wires:

TÜV: EAS 2-UP, EAS 4 M-UP, SAS 2-UP, SAS 4-UP, CN 22/9 N-UP

ABS: CN 22/9N-UP, **GL:** CN 22/9 N-UP, **DNV:** CN 22/9 N-UP, CN 23/12-UP, **LR:** CN 22/9N-UP