

## Classification

**EN ISO 14174**

SA AR 1 77 AC H5

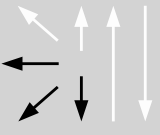
## Characteristics and typical fields of application

BB 306 is an agglomerated flux designed for joining applications on general-purpose structural and pipe steels. It is suited for direct and alternating current. It can be used for single- and multi-wire welding with high welding speed using the two-run technique as well as for fillet welding. Very good slag removability.

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

	SiO <sub>2</sub> +TiO <sub>2</sub>	Al <sub>2</sub> O <sub>3</sub> +MnO	CaF <sub>2</sub> +CaO+MgO
wt.-%	24	50	14

## Operating data

	<b>Polarity</b> DC ( + ) / DC ( - ) AC	<b>Basicity acc. to Boniszewski:</b>	0.8 Mol.%	0.6 wt-%
		<b>Grain size acc. to EN ISO 14174:</b>	3 – 16 (0,3 – 1,6 mm)	
		<b>Flux consumption:</b>	0,7 – 1,6 kg flux per kg wire	
		<b>Redrying:</b>	300 – 350°C, 2-10h	

## Typical Composition of all-weld Metal with different Wires

SAW wires	C	Si	Mn	Mo
BÖHLER EMS 2	0.06	0.60	1.40	
BÖHLER EMS 3	0.07	0.60	1.60	
BÖHLER EMS 2 Mo	0.06	0.60	1.40	0.45

## Classification

	wire	wire flux/combination	
	EN ISO	EN ISO	AWS A5.17 / A5.23
BÖHLER EMS 2	S2	S 42 3 AR S2	F7A2-EM12K / F48A2-EM12K
BÖHLER EMS 3	S3	S 42 3 AR S3	F7A2- EH10K / F48A2-EH10K
BÖHLER EMS 2 Mo	S2Mo	S 46 2 AR S2Mo	F8A0-EA2-A4 / F55A2-EA2-A4

## Approvals

Approval is available for BÖHLER BB 306 together with the BÖHLER-wires:

TÜV: EMS 2, EMS 2 Mo

DB: EMS 2