

Classification

EN ISO 14174

SA AB 1 67 AC H5

Characteristics and typical fields of application

BÖHLER BB 400 is an agglomerated flux of aluminate basic type designed for joining and surfacing applications with general-purpose structural steels, fine grained structural steels, boiler and pipe steels. The flux is characterized by its low silicon and moderate manganese pickup. It can be used on DC and AC. Its good welding characteristics and the technological properties of the weld metal produced with different wires permit universal use.

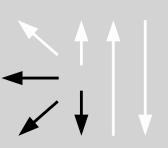
Base materials

Structural steels, fine grained structural steels, boiler steels, pipe steels

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

	SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂
wt.-%	20	30	28	16

Operating data

	Polarity DC (+) / DC (-) AC	Basicity acc. to Boniszewski: 2.3 Mol. % 1.7 weight %
		Grain size acc. to EN ISO 14174: 3 – 20 (0.3 – 2.0 mm)
		Flux consumption: 1.0 kg flux per kg wire
		Redrying: 300 – 350 °C, 2h

Typical Composition of all-weld Metal with different Wires

SAW wires	C	Si	Mn	Mo
BÖHLER EMS 2	0.06	0.35	1.35	
BÖHLER EMS 2 Mo	0.06	0.35	1.35	0.35
BÖHLER EMS 3	0.07	0.35	1.60	

Wire classification

	EN ISO 14171-A	AWS A5.17
BÖHLER EMS 2	S2	EM12K
BÖHLER EMS 2 Mo	S2Mo	EA2
BÖHLER EMS 3	S3	EH10K

Approvals

DB (51.014.03)

Approval is available for BÖHLER BB 400 together with the BÖHLER-wires:

TÜV, DB: EMS 2, EMS 2 Mo