

Classification

EN ISO 14174

SA FB 1 55 AC

Characteristics and typical fields of application

BÖHLER BB 430 is a basic agglomerated welding flux with high basicity, for welding high temperature and creep resistant steels. It is characterised by its neutral metallurgical behaviour. When used in combination with suitable wire electrodes the weld metal displays high toughness properties at low/subzero temperatures, even after step-cooling heat treatment

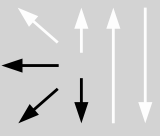
Base Materials

HCM2S (P23/T23 acc. to ASTM A213 code case 2199)
7CrMoVTiB10-10, P24 acc. to ASTM A 213 (Draft)

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

	SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂
wt.-%	15	35	21	26

Operating data

	Polarity DC (+)	Basicity acc. to Boniszewski:	2.6 weight %
		Bulk density:	1.0 kg / dm ³
		Grain size acc. to EN ISO 14174:	3 – 16 (0.3 – 1.6 mm)
		Flux consumption:	1.0 kg flux per kg wire
		Redrying:	300 – 350 °C, around 2h

Typical Composition of All-weld Metal with different Wires

SAW wires	C	Si	Mn	Cr	Mo	V	W	Nb
BÖHLER P 23-UP	0.06	0.4	0.65	2.1		0.18	1.6	0.04
BÖHLER P 24-UP	0.08	0.3	0.75	2.4	0.95	0.20		0.04
	Wire classification							
	EN ISO 24598-A				AWS A5.23			
BÖHLER P 23-UP	S S ZCrWV2 1.5				EB23			
BÖHLER P 24-UP	S S ZCrMo2VNb				EB24			