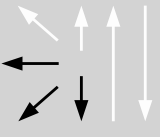


Classification											
EN ISO 14174											
SA FB 2 AC											
Characteristics and typical fields of application											
BÖHLER BB 444 is a highly basic agglomerated welding flux, designed for welding and cladding of NiCr(Mo) alloys. Highly resistant against hot cracking thanks to its low level of Si pick up.											
Base materials											
Nickel and nickel alloys											
Composition of sub-arc welding flux (wt. %)											
	SiO <sub>2</sub> +TiO <sub>2</sub>	Al <sub>2</sub> O <sub>3</sub> +MnO	CaO+MgO	CaF <sub>2</sub>							
wt-%	7	30	40	20							
Operating data											
	<b>Polarity</b>		<b>Basicity acc. to Boniszewski:</b>		4.5 Mol. %						
	DC ( + ) / DC ( - )		<b>Bulk density:</b>		1.0 kg / dm <sup>3</sup>						
	AC		<b>Grain size acc. to EN ISO 14174:</b>		3 – 16 (0.3 – 1.6 mm)						
			<b>Flux consumption:</b>		1.0 kg flux per kg wire						
		<b>Redrying:</b>		300 – 350 °C / around 2h							
Typical Composition of all-weld Metal with different Wires											
SAW wires	C	Si	Mn	Cr	Mo	Ni	Nb	Ti		Co	Fe
BÖHLER NIBAS 70/20-UP	0.02	0.25	3.0	20.0		bal.	2.4	+			< 1.0
BÖHLER NIBAS 625-UP	0.02	0.25	0.2	21.5	8.5	bal.	3.2				< 1.0
BÖHLER NIBAS C 24-UP	0.015	0.20	< 0.5	22.5	15.8	bal.					< 1.0
BÖHLER NIBAS 617-UP	< 0.06	< 0.40	< 0.30	21.2	8.9	bal.		+	Al 1.1	10.0	< 1.0
BÖHLER NIBAS C 276-UP	< 0.012	0.15	0.5	15.5	16.0	bal.		+	W 3.3		< 7.0
			Wire classification								
			EN ISO 18274				AWS A5.14				
BÖHLER NIBAS 70/20-UP			S Ni 6082 (NiCr20Mn3Nb)				ERNiCr-3				
BÖHLER NIBAS 625-UP			S Ni 6625 (NiCr22Mo9Nb)				ERNiCrMo-3				
BÖHLER NIBAS C 24-UP			S Ni 6059 (NiCr23Mo16)				ERNiCrMo-13				
BÖHLER NIBAS 617-UP			S Ni 6617 (NiCr22Co12Mo9)				ERNiCrCoMo-1				
BÖHLER NIBAS C 276-UP			S Ni 6276 (NiCr15Mo16Fe6W4)				ERNiCrMo-4				