

BÖHLER EAS 2-UP // BB 202

SAW wire/flux-combination, high-alloyed, stainless

Classifications			
SAW solid wire	Sub-arc flux		
EN ISO 14343-A	EN ISO 14343-B	AWS A5.9	EN ISO 14174
S 19 9 L	SS308L	ER308L	SA FB 2 DC

Characteristics and typical fields of application

SAW-wire/flux combination for multi-pass welding of stainless steel grades like 1.4306 / 304L. Smooth beads, easy slag removal without any slag residues and good welding characteristics even for fillet welds are very much appreciated by users. Suited for service temperatures from -196 °C to +350 °C.

BÖHLER BB 202 is a fluoride-basic agglomerated flux providing low flux consumption and a low hydrogen weld metal. For information regarding this sub-arc welding flux see our detailed data sheet.

Base materials

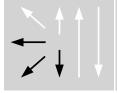
1.4306 X2CrNi19-11, 1.4301 X5CrNi18-10, 1.4311 X2CrNiN18-10, 1.4312 GX10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10
AISI 304, 304L, 304LN, 302, 321, 347; ASTM A157 Gr. C9, A320 Gr. B8C or D

Typical analysis of the wire and of all-weld metal (wt%)								
	С	Si	Mn	Cr	Ni			
SAW wire wt%	≤ 0.02	0.45	1.8	20.0	9.8			
all-weld metal %	≤ 0.02	0.55	1.3	19.5	9.8			

Mechanical properties of all-weld metal									
Condition	Yield strength R _{p0,2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J					
	MPa	MPa	%	+20 °C	−50 °C	−100 °C	−196 °C		
u	≥ 320	≥ 520	≥ 25	≥ 80	≥ 60	≥ 50	≥ 32		

u untreated, as welded

Operating data



Polarity: DC (+)/DC (-)

Redrying of sub-arc flux: $300 - 350 \,^{\circ}\text{C} / 2 - 10 \,^{\circ}\text{h}$

ø (mm) 0.3

Approvals

SAW wire/flux combination: TÜV (07509.)

SAW solid wire: TÜV (02604.), DB (52.014.11), SEPROZ, CE