

## Classifications

SAW solid wire			Sub-arc flux
<b>EN ISO 14343-A</b>	<b>EN ISO 14343-B</b>	<b>AWS A5.9</b>	<b>EN ISO 14174</b>
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 X2CrNi18-10, 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.-%)

	C	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 <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	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

	<b>Polarity:</b> DC ( + ) / DC ( - )	<b>Redrying of sub-arc flux:</b> 300 – 350 °C / 2 – 10 h	<b>ø (mm)</b> 0.3
---	---	---	----------------------

## Approvals

SAW wire/flux combination: TÜV (07509.)

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