BÖHLER SAS 4-UP // BB 202

SAW wire/flux combination, high-alloyed, chemical resistant

Classifications

SAW solid wire:			Sub arc flux:
EN ISO 14343-A	**EN ISO 14343-B**	**AWS A5.9**	**EN ISO 14174**
S 19 12 3 Nb	SS318	ER318	SA FB 2 DC

Characteristics and typical fields of application

SAW wire/flux-combination for multi-pass welding of stainless steel grades like 1.4571 / 316Ti.

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 –120 °C to +400 °C.

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

Base materials

1.4571 X6CrNiMoTi17-12-2, 1.4580 X6CrNiMoNb17-12-2, 1.4401 X5CrNiMo17-12-2, 1.4581 GX5CrNiMoNb19-11-2, 1.4437 GX6CrNiMo18-12, 1.4583 X10CrNiMoNb18-12, 1.4436 X3CrNiMo17-13-3

AISI 316L, 316Ti, 316Cb

Typical analysis of the wire and of all-weld metal (wt.-%)

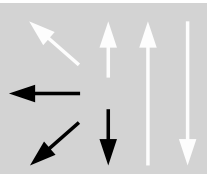
	C	Si	Mn	Cr	Ni	Mo	Nb
SAW wire wt-%	0.035	0.50	1.7	19.5	11.4	2.8	0.65
all-weld metal %	0.03	0.60	1.2	18.0	11.4	2.8	0.55

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	–120 °C
u	≥ 350	≥ 550	≥ 25	85	≥ 70	≥ 32

u untreated, as welded

Operating data



Polarity:	Redrying of sub arc flux:	ø (mm)
DC (+) / DC (–)	300 – 350 °C / min. 2 h	3.0

Approvals

TÜV (07511.), TÜV (09171. with BB 203)

SAW solid wire: TÜV (02604.), DB (52.014.12), SEPROZ, CE