BÖHLER SKWA-UP // BB 203

SAW wire/flux combination, high-alloyed, stainless

Classifications

SAW solid wire:	Sub arc flux:
EN ISO 14343-A	**EN ISO 14174**
S Z17 Mo	SA FB 2 DC

Characteristics and typical fields of application

SAW wire/flux combination of type 17 % Cr 1 % Mo for surfacing on sealing faces of gas, water and steam valves and fittings made from unalloyed or low-alloy steels, for service temperatures up to +450 °C. Excellent anti-friction properties. The weld deposit is still machinable. Scaling resistant up to +900 °C

BÖHLER BB 203 produces well contoured and smooth welding beads. It offers an especially low flux consumption. Beside good slag detachability the flux features good fillet weld capabilities.

For information regarding this sub-arc welding flux see our detailed data sheet.

Base materials

Surfacings: all weldable backing materials, unalloyed, low-alloyed

Joint welds: corrosion resistant Cr- steels as well as other similar- alloyed steels with C- contents up to 0.20% (repair welding). Be careful with dilution and welding technology.

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

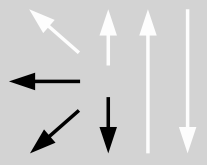
	C	Si	Mn	Cr	Mo	Ni
SAW wire wt-%	0.2	0.65	0.55	17.0	1.1	0.4
all-weld metal %	0.15	0.65	0.55	16.5	1.1	0.4

Mechanical properties of all-weld metal

Condition	Brinell-hardness
	HB
u	320 – 420
a	**200**

u untreated, as welded
a annealed, 720 °C/2 h

Operating data



Polarity:	**Redrying of sub arc flux:**	**ø (mm)**
DC (+) / DC (–)	300 – 350 °C / min. 2 h	3.2