BÖHLER BB 910

SAW flux, fluoride-basic type

Classification

EN ISO 14174

SA FB 2 55 DC H5

Characteristics and typical fields of application

BÖHLER BB 910 is an agglomerated fluoride-basic special welding flux with high basicity for multipass welding of creep resistant 9 % Cr-steels like P91/T91, P911 and NF 616 (grade P92/T92). The metallurgical behaviour concerning Si and Mn is neutral. The flux BB 910 produces well contoured and smooth welding beads with good slag release as well as appropriate weld metal ductility and impact behaviour after tempering. BÖHLER BB 910 is a hydrogen-controlled welding flux with hydrogen contents of maximum 5 ml / 100 g weld deposit.

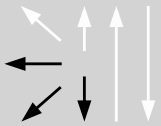
Base materials

high creep resistant 9%Cr-steels like grade P91/T91, X10CrMoVNb9-1 (1.4903), grade P92/T92, NF616 and X11CrMoWVNb9-1-1 (1.4905)

Composition of sub-arc welding flux (wt. %)

	SiO_2+Al_2O_3	CaF_2+CaO+MgO
wt-%	35	60

Operating data



Polarity
DC (+) / DC (–)

Basicity acc. to Boniszewski:	2.9 weight %
Bulk density:	1.0 kg / dm^3
Grain size acc. to EN ISO 14174:	3 – 20 (0.3- – 2.0 mm)
Flux consumption:	1.0 kg flux per kg wire
Redrying:	300 – 350 °C, around 2h

Typical Composition of all-weld Metal with different Wires

SAW wires	C	Si	Mn	Cr	Ni	Mo	V	Nb	W	N
BÖHLER C 9 MV-UP	0.1	0.22	0.60	8.70	0.45	0.93	0.18	0.05		0,04
BÖHLER P 92-UP	0.09	0.22	0.70	8.90	0.45	0.43	0.18	0.05	1.7	0,04

	wire classification	**classification for wire flux/combination**	
	EN ISO 24598	**EN ISO**	**AWS A5.23**
BÖHLER C 9 MV-UP	S S CrMo91	S S CrMo91 FB	F9PZ-EB9-B9 / F62PZ-EB9-B9
BÖHLER P 92-UP	S ZCrMoWVNb9 0.5 1.5	S S ZCrMoWVNb9 0.5 1.5 FB	-

Approvals

Approval is available for BÖHLER BB 910 together with the BÖHLER-wires:
TÜV: C 9 MV-UP, P 92-UP
SEPROZ: C 9 MV-UP