

Agglomerated Welding Flux BF 10

Flux type: Fluoride-Basic

Classification: ISO 14174 – S A FB 1 55 AC H5 *)
(EN 760 – SA FB 1 55 AC)

Characteristics:

BF 10 is a fluoride-basic flux with high basicity and low impurity levels such as P and S. As a result of low oxygen levels in the weld deposits uniform mechanical properties with high toughness values at low temperature are achieved. Because of the almost neutral slag-reactions the chemical analysis of the weld metal can be excellently controlled through the selection of appropriate wire electrodes.

BF 10 is suitable for welding on D.C. and A.C. using single and tandem wire processes.

Application:

Low hydrogen levels after redrying according to the recommendation on the flux labels and optimum mechanical properties, whilst observing recommended heat control, enable the welding of:

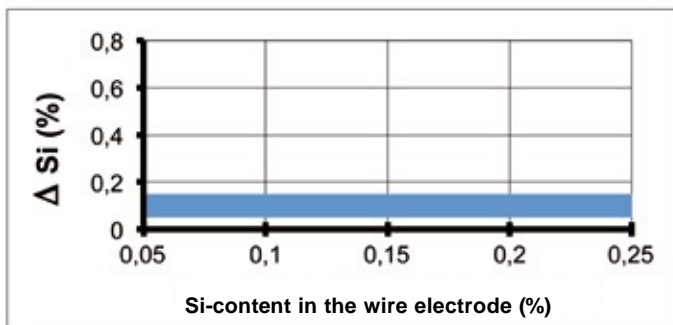
- thick-walled constructional steels with yield strengths of up to 420 MPa
- OFF-SHORE applications up to 460 MPa yield strength on steels such as BS 4360-Grade 50 D and S355 2G3 acc. to DIN EN 10025 (previous designation St 52-3N)
- fine grain structural steels for low temperature requirements with impact toughness at –60 °C or below
- high tensile fine grain steels such as S690QL1 and N-A-XTRA 70
- boiler and vessel steels such as 16Mo3/A204 grade A, 13CrMo4-5/A387 grade 12 or 10CrMo9-10/A387 grade 22

Characteristic chemical Constituents:

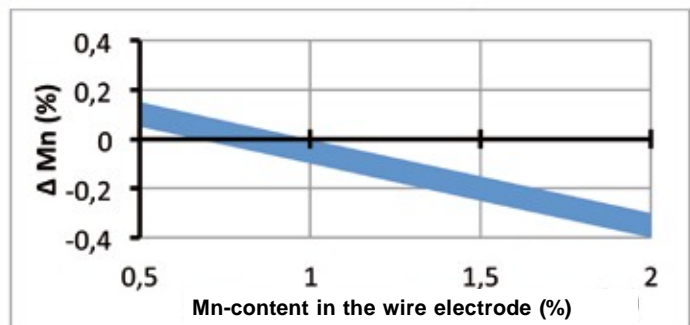
SiO ₂ + TiO ₂	Al ₂ O ₃ + MnO	CaO + MgO	CaF ₂
15 %	20 %	40 %	25 %
Basicity according to Boniszewski: ~3.0			

Metallurgical behaviour acc. to ISO 14174 type of current DC:

Pick-up Silicon



Pick-up/ Burn-out Manganese



Flux density: 0.95 kg/dm³ (l)

Grain size acc. to ISO 14174: 2 – 20 (Tyler 8 x 65)

Current-carrying capacity: up to 800 A (DC or AC) using one wire

*) Diffusible hydrogen content H5: determined in deposited metal acc. to the method described in ISO 3690
Type of current DC; redrying conditions 300 – 350 °C

All-weld metal multiple pass classification of wire-flux combinations:

Wire electrode (ISO 14171-A ISO 24598-A ISO 26304-A)	AWS A5.17/.2 3	Test assembly ISO 15792-1: type 1.3	AWS A5.17M/5.23M	AWS A5.17/5.23
BA-S2	EM12(K)	ISO 14171-A S 38 6 FB S2	F48A6/P6-EM12(K)	F7A8-EM12(K)
BA-S3	EH10K	ISO 14171-A S 46 6 FB S3	F55A6/F49P6-EH10K	F8A8/F7P8-EH10K
BA-S3Si	EH12K	ISO 14171-A S 46 6 FB S3Si	F55A6/F49P6-EH12K	F8A8/F7P8-EH12K
BA-S2Mo	EA2	ISO 14171-A S 46 4 FB S2Mo	F55A4/F49P4-EA2-A2	F8A4/F7P4-EA2-A2
BA-S2Ni1	ENi1	ISO 14171-A S 42 7 FB S2Ni1	F49A7/P7-ENi1-Ni1	F7A10/P10-ENi-Ni1
BA-S2Ni2	ENi2	ISO 14171-A S 46 8 FB S2Ni2	F55A7/F49P7-ENi2-Ni2	F8A10/F7P10-ENi-Ni2
BA-S2Ni3	ENi3	ISO 14171-A S 50 8 FB S2Ni3	F55A7/P7-ENi3-Ni3	F8A10/P10-Eni3-Ni3
BA-S3NiMo1/4	ENi5	ISO 14171-A S466FBS3Ni1Mo0,2	F55A6/P6-ENi5-Ni5	F8A8/P8-Eni5-Ni5
BA-S3NiMo1	EF3	ISO 26304-A S 55 6 FB S3Ni1Mo	F62A6/P6-EF3-F3	F9A8/P8-EF3-F3
BA-S3NiMo1,5	EM2 mod.	ISO 14171-A S 50 6 FB S3Ni1,5Mo	F62P6-EM2mod.-M2	F9P8-EM2mod.-M2
BA-S3NiCrMo2,5	EM4 mod.	ISO 26304-A S 69 6 FB S3Ni2,5CrMo	F76A6/P6-EM4 mod.-M4	F11A8/P8-EM4 mod.-M4
BA-S2CrMo1	EB2(R)	ISO 24598-A S S CrMo1 FB	F55P2-EB2R-B2R	F8P0-EB2R-B2R
BA-S1CrMo2	EB3(R)	ISO 24598-A S S CrMo2 FB	F55P2-EB3R-B3R	F8P0-EB3R-B3R

Chemical composition of all-weld metal acc. to EN ISO 15792-1 and AWS A5.17/5.23: (characteristical values in wt. %)

Wire electrode		C	Si	Mn	Mo	Ni	Cr
BA-S2	EM12(K)	0.05-0.09	0.1-0.3	0.8-1.2			
BA-S3	EH10K	0.05-0.09	0.1-0.3	1.1-1.5			
BA-S3Si	EH12K	0.05-0.09	0.2-0.5	1.2-1.6			
BA-S2Mo	EA2	0.05-0.09	0.1-0.3	0.8-1.2	0.5		
BA-S2Ni1	ENi1	0.05-0.09	0.1-0.3	0.8-1.2		1.0	
BA-S2Ni2	ENi2	0.05-0.09	0.1-0.3	0.8-1.2		2.0	
BA-S2Ni3	ENi3	0.05-0.09	0.1-0.3	0.8-1.2		3.0	
BA-S3NiMo1/4	ENi5	0.05-0.09	0.2-0.4	1.1-1.5	0.25	1.0	
BA-S3NiMo1	EF3	0.05-0.09	0.1-0.3	1.2-1.6	0.5	1.0	
BA-S3NiMo1,5	EM2 mod.	0.05-0.09	0.1-0.3	1.2-1.6	0.4	1.6	
BA-S3NiCrMo2,5	EM4 mod.	0.05-0.09	0.1-0.3	1.2-1.6	0.5	2.5	0.5
BA-S2CrMo1	EB2	0.05-0.09	0.1-0.3	0.5-0.9	0.5		1.2
BA-S1CrMo2	EB3	0.05-0.09	0.1-0.3	0.4-0.7	1.0		2.3

Mechanical properties of all-weld metal acc. to EN ISO 15792-1 and AWS A5.17/5.23: (characteristical values)

Wire electrode		Heat treat -	YS MPa	UTS MPa	Elong. %	Impact ISO-V (J)				
						RT	-20 °C -4 °F	-40 °C -40 °F	-60 °C -76 °F	-80 °C -112 °F
BA-S2	EM12(K)	AW	>400	>490	>26	>120	>100	>70	>47	
BA-S3	EH10K	AW	>470	>560	>25	>120	>100	>80	>47	
		S*)	>400	>500	>28	>120	>100	>80	>47	
BA-S3Si	EH12K	AW	>470	>550	>25	>120	>100	>80	>47	
		S*)	>430	>530	>26	>120	>100	>90	>47	
BA-S2Mo	EA2	AW	>490	>570	>23	>100	>90	>47		
		S**)	>440	>530	>24	>100	>90	>47		
BA-S2Ni1	ENi1	AW	>440	>540	>26	>160	>140	>120	>90	>47/- 70°C
BA-S2Ni2	ENi2	AW	>470	>550	>25	>160	>140	>120	>80	>47
		S*)	>420	>520	>26	>160	>140	>120	>90	>47
BA-S2Ni3	ENi3	AW	>500	>590	>24	>160	>150	>120	>100	>27/- 101°C
		S*)	>470	>560	>25	>160	>150	>120	>100	>27/- 101°C
BA-S3NiMo1/4	ENi5	AW	>480	>560	>26	>160	>140	>120	>47	
		S*)	>470	>550	>26	>160	>150	>120	>47	
BA-S3NiMo1	EF3	AW	>570	>670	>22	>140	>110	>80	>47	
		S*)	>550	>640	>22	>150	>110	>80	>47	
BA-S3NiMo1,5	EM2mod.	AW	>590	>690	>22	>140	>100	>80		
		S***)	>570	>660	>22	>150	>100	>70		
BA-S3NiCrMo2,5	EM4mod.	AW	>690	>820	>18	>140	>90	>70	>47	
BA-S2CrMo1	EB2	S****)	>470	>570	>22	>100	>47			
BA-S1CrMo2	EB3	S****)	>470	>570	>23	>100	>47			

Post Weld Heat Treatment: *) 590 °C/15 h **) 620 °C/15 h ***) 605 °C/2 h *****) 700 °C/10 h

Approvals:

VdTUEV 1153 / TÜV-Wien

Deutsche Bahn

ABS (American Bureau of Shipping)

DNV

with wire electrodes:

S2, S3, S3Si, S2Mo, S2Ni2, S3Ni1Mo and S3Ni2,5CrMo, S3NiMo0,2, SCrMo1

S3, S3Si, S2Mo, S2Ni2, S3Ni1Mo, S3NiMo0,2, S3Ni2,5CrMo

EH12K(S3Si), EF3 (S3Ni1Mo)
EM4 mod. (S3Ni2,5CrMo)

EM4 mod. (S3Ni2,5CrMo)

Packaging: 25 kg PE-coated Aluminium bags

Storage and redrying:

Unopened originally packed flux bags can be stored up to 1 year in dry storage rooms after date of delivery ex factory.

Redrying conditions specific to the flux: 300 – 350 °C effective flux temperature.