

Флюсы для дуговой сварки ELIFLUX

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Submerged Arc Welding Flux

ELIFLUX BAR

Standards

TS EN ISO 14174	: SA AR 1 77 AC
EN ISO 14174	: SA AR 1 77 AC
AWS A5.17	: F6AZ-EL12 / F7AZ-EM12

Basicity
0.7

Mechanical Properties

SAW Wire	AWS A5.17	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)
					0°C
S1	F6AZ-EL 12	360	460	26	47
S2	F7AZ-EM 12	400	500	30	60

Chemical Composition of Weld Metal - % (Typical)

SAW Wire	C	Si	Mn
S1	0.07	0.50	1.10
S2	0.07	0.60	1.35

Features and Applications

- A type of SAW rutile flux structured from agglomerated aluminate
- Applicability in single-pass joint welding and fillet welding of particularly spiral welded pipes, LPG cylinders, general-purpose construction steels, boiler sheet, and shipbuilding steels
- Low consumption of flux. Basicity: 0.7
- Straight and nonporous welding beads
- Formation of very easily-removed slag
- Requirement of re-drying at 250-350°C for 2 hours

Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800006	25	Kraft Bag

Approvals: S1 x ELIFLUX BAR: BV, DNV-GL, TL, ABS, LR, CE • S2 x ELIFLUX BAR: BV, ABS, CE, DB
ELIFLUX BAR: CE, SEPRO

Submerged Arc Welding Flux

ELIFLUX BAS

Standards

TS EN ISO 14174	: SA AB 1 67 AC
EN ISO 14174	: SA AB 1 67 AC
AWS A5.17	: F7 A5-EM12 / F7A5-EM12K

Basicity
1.60

Mechanical Properties

SAW Wire	AWS A5.17	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((L ₀ =d ₀) (%))	Impact Strength ISO-V(J)		
					0°C	-40°C	-45°C
S2	F7A5-EM 12	430	520	30	110	75	min.47
S2Si	F7A5-EM 12K	465	570	30	100	85	min.47

Chemical Composition of Weld Metal - % (Typical)

SAW Wire	C	Si	Mn
S2	0.05	0.30	1.40
S2 Si	0.06	0.40	1.40

Features and Applications

- SAW flux type composed of agglomerated aluminate-basic
- Basicity: 1.6 (According to Boniszewski formula)
- Applicability in single and multi-pass welding of general-purpose construction steels
- Formation of easily-removed slag
- Requirement of re-drying at 300 - 350°C for 2 hours

Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800035	25	Kraft Bag

Approvals: CE, SEPRO

Submerged Arc Welding Flux

ELIFLUX BBR-AG

Standards

TS EN ISO 14174	: SA AB 1 67 AC H5
EN ISO 14174	: SA AB 1 67 AC H5
AWS A5.17	: F6AZ-EL12 / F7A0-EM12
	F7A0-EM12K

Basicity
1.1

Mechanical Properties

SAW Wire	AWS A5.17	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)	
					0°C	-20°C
S1	F6AZ-EL12	370	480	30	55	---
S2	F7A0-EM12	410	490	32	---	50
S2Si	F7A0-EM12K	420	510	29	---	50

Chemical Composition of Weld Metal - % (Typical)

SAW Wire	C	Si	Mn
S1	0.06	0.30	0.90
S2	0.10	0.35	1.20
S2Si	0.07	0.40	1.30

Features and Applications

- Agglomerated aluminate-basic type welding flux.
- Especially suitable for singlepass joining and fillet welding of LPG cylinders, welded spiral pipes (with S2 combination up to X52 pipe), general constructions, steels, boiler plates and ship plates.
- The weld bead looks more like a rutile type weld bead.
- Easy removable slag.
- Before using: The welding flux should be dried 2h between 300°C - 350°C.

Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800026	25	Kraft Bag

Approvals: CE, SEPRO

Submerged Arc Welding Flux

ELIFLUX BFB

Standards

TS EN ISO 14174	: SA AB 1 68 AC H5
EN ISO 14174	: SA AB 1 68 AC H5
AWS A5.17	: F6A2-EL12 / F7A4-EM12 / F7A2-EM12K / F7A4-EH12K
AWS A5.23	: F8A4-EA2-A2

Basicity
1.4

Mechanical Properties

SAW Wire	AWS A5.17 / AWS A5.23	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)		
					-20°C	-30°C	-40°C
S1	F6A2-EL12	380	480	28	55	47	---
S2	F7A4-EM 12	460	525	30	70	55	50
S2 Si	F7A2-EM12K	430	530	28	80	70	---
S3 Si	F7A4-EH12K	460	550	27	---	---	60
S2 Mo	F8A4-EA2-A2	490	600	26	90	---	60

Chemical Composition of Weld Metal - % (Typical)

SAW Wire	C	Si	Mn	Mo
S1	0.06	0.25	1.20	---
S2	0.07	0.35	1.50	---
S2 Si	0.05	0.40	1.70	---
S3 Si	0.07	0.40	1.80	---
S2 Mo	0.06	0.40	1.40	0.50

Features and Applications

- A type of submerged welding (SAW) basic flux structured from agglomerated aluminate.
- Applicability in single-and multi-pass (butt-) joint welding and fillet welding of general-purpose construction steels, shipbuilding steel, boiler sheet, heat-resisting steels, and fine-grained steels.
- Low consumption of flux.
- Basicity: 1.4
- High toughness of weld metal at low temperatures.
- Formation of easily-removed slag.
- Requirement of re-drying at 300°C - 350°C for 2 hours.

Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800002	25	Kraft Bag

Approvals: ELIFLUX BFB: CE, SEPRO • S2Si x ELIFLUX BFB: ABS, LR, CE
S2 x ELIFLUX BFB: TL, DNV-GL, BV, ABS, LR, RS, NK, RINA, DB • S2Mo x ELIFLUX BFB: BV, ABS, CE

Submerged Arc Welding Flux

ELIFLUX PIPE

Standards

TS EN ISO 14174	: SA AB 1 78 AC H5
EN ISO 14174	: SA AB 1 78AC H5
AWS A5.17	: F7A4-EM12
AWSA5.23	: F7A4-EA2-A2 / F8A4-EA4-A4

Basicity
1.7

Mechanical Properties

SAW Wire	AWS A5.17/ AWS A5.23	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)		
					0°C	-20°C	-40°C
S2	F7A4-EM 12	460	550	26	---	75	50
S2 Mo	F7A4 EA2-A4	510	640	25	---	---	60
S3 Mo	F8A4-EA4-A4	530	620	25	100	---	50

Chemical Composition of Weld Metal - % (Typical)

SAW Wire	C	Si	Mn	Mo
S2	0.05	0.40	1.35	---
S2 Mo	0.06	0.40	1.40	0.50
S3 Mo	0.06	0.40	1.60	0.45

Features and Applications

- SAW flux type composed of agglomerated aluminate Basic.
- Basicity of the flux According to Boniszewski Formula is 1.7
- Excellent removal of slags of weld beads formed at high temperatures
- Suitability for use in both bilateral and tandem (AC/DC) welding operations.
- Sufficiently high toughness of weld metals obtained particularly by 2-pass welding operations.
- Suitability for use in welding of high-strength steels.
- Process requirement of re-drying at 300°C - 350°C for 2 hours.

Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800019	25	Kraft Bag

Approvals: CE, SEPRO

Submerged Arc Welding Flux

ELIFLUX BAB-S

Standards

TS EN ISO 14174	: SA AB 1 68 AC H5
EN ISO 14174	: SA AB 1 68 AC H5
AWS A5.17	: F7A4-EH12K/ F7A4-EM12 F7A4-EM12K
AWS A5.23	: F8A4-EA2-A3 / F11A4-EM4(mod)-M4

Basicity
2.1

Mechanical Properties

SAW Wire	AWS A5.17 AWS A5.23	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)		
					-20°C	-30°C	-40°C
S2	F7A4-EM12	430	525	29	---	---	60
S2Si	F7A4-EM12K	440	550	28	100	---	65
S2 Mo	F8A4-EA2-A3	500	600	26	---	---	60
S3Si	F7A4-EH12K	545	645	26	---	---	60
S3NiCrMo2.5	F11A4-EM4(mod)-M4	735	855	18	---	70	60

Chemical Composition of Weld Metal - % (Typical)

Saw Wire	C	Si	Mn	Mo	Ni	Cr
S2	0.08	0.40	1.50	---	---	---
S2 Si	0.07	0.45	1.60	---	---	---
S2 Mo	0.07	0.55	1.70	0.50	---	---
S3 Si	0.07	0.60	1.70	---	---	---
S3 NiCrMo 2.5	0.05	0.65	1.80	0.48	2.05	0.35

Features and Applications

- SAW Flux type is composed of agglomerated Aluminate Basic.
- Weld beads of excellent surface appearance.
- Slag can be removed easily.
- This product has high current carrying capacity.
- GeKa ELIFLUX BAB-S is suitable for multipass and tandem welding especially for manufacturing of spiral pipe.
- It has suitable of high working speed.
- Suitable for the use of welding of high strength steels.
- Process requirement of re-drying at 300°C - 350°C for 2 hours.

Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800022	25	Kraft Bag

Approvals: ELIFLUX BAB-S: CE, SEPRO • S2 x ELIFLUX BAB-S: CE, ABS • S3Si x ELIFLUX BAB-S: ABS
S2Mo x ELIFLUX BAB-S: ABS • S3NiCrMo2.5 x ELIFLUX BAB-S: ABS,

Submerged Arc Welding Flux

ELIFLUX BFPP

Standards

TS EN ISO 14174	: SA AB 1 66 AC H5
EN ISO 14174	: SA AB 1 66 AC H5
AWS A5.17	: F7A2-EM12/F7A2-EM12K
AWS A5.23	: F8A4-EA2-A2

Basicity
1.6

Mechanical Properties

SAW Wire	AWS A5.17 AWS A5.23	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (Lo=5do) (%)	Impact Strength ISO-V(J)	
					-30°C	-40°C
S2	F7A2-EM 12	430	520	29	60	---
S2 Si	F7A2 EM12K	440	515	30	65	---
S2 Mo	F8A4-EA2-A2	490	595	26	---	60

Chemical Composition of Weld Metal - % (Typical)

SAW Wire	C	Si	Mn	Mo
S2	0.06	0.35	1.20	---
S2Si	0.07	0.40	1.25	---
S2 Mo	0.07	0.40	1.30	0.50

Features and Applications

- GeKa ELIFLUX BFPP, is agglomerated aluminate basic flux for submerged arc welding
- It features high impact toughness and low hydrogen content
- It is suitable for double wire welding and narrow gap welding of thick steel plates and spiral welded pipes
- With suitable wires, also can be used for welding of pressure vessels
- Flux should be re-dried before use for 2 hours at 300°C - 350°C

Operating Data

Product Code	Package Weight (Kg)	Package Type
6010800015	25	Kraft Bag

Approvals: SEPRO, CE

Submerged Arc Welding Flux

ELIFLUX BFPV

Standards

TS EN ISO 14174	: SA FB 1 66 AC H5
EN ISO 14174	: SA FB 1 66 AC H5
AWS A5.17	: F7A2-EM12/F7A2-EM12K
AWS A5.23	: F8A4-EA2-A2/F8A5-EA4-A3/ F11A8-EM4(mod)-M4

Basicity
2.8

Mechanical Properties

SAW Wire	AWS A5.17 AWS A5.23	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%)	Impact Strength ISO-V(J)			
					-30°C	-40°C	-50°C	-60°C
S2	F7A2-EM12	430	520	29	60	---	---	---
S2 Si	F7A2-EM12K	440	515	30	65	---	---	---
S2 Mo	F8A4-EA2-A2	490	595	26	---	60	---	---
S3Si	F8A5-EA4-A3	500	588	27	---	100	80	---
S3NiCrMo2.5	F11A8-EM4(mod.)-M4	700	775	23	---	55	45	min.27

Chemical Composition of Weld Metal - % (Typical)

Saw Wire	C	Si	Mn	Mo	Cr	Ni
S2	0.06	0.35	1.20	---	---	---
S2 Si	0.07	0.40	1.25	---	---	---
S2 Mo	0.07	0.40	1.30	0.50	---	---
S3 Mo	0.05	0.30	1.75	0.50	---	---
S3 NiCrMo 2.5	0.06	0.40	1.75	0.50	0.40	2.10

Features and Applications

- GeKa ELIFLUX BFPV, high basic, is agglomerated fluoride basic flux for submerged arc welding.
- It features high impact toughness and low hydrogen content
- It is suitable for double wire welding and narrow gap welding of thick steel plates, pressure vessels
- Flux should be re-dried before use for 2 hours at 300°C - 350°C

Operating Data

Product Code	Package Weight (Kg)	Package Type
6010800016	25	Kraft Bag

Approvals: SEPRO, CE

Submerged Arc Welding Flux

ELIFLUX BFF

Standards

TS EN ISO 14174	: SA FB 1 65 DC H5
EN ISO14174	: SA FB 1 65 DC H5
AWS A5.17	: F7A4-EM12/F7A4-EM12K/ F7A4-EH12K
AWS A5.23	: F8A4-EA2-A2/ F9A4-EF3(mod)-F3 / F11A8-EM4(mod)-M4

Basicity
3.0

Mechanical Properties

SAW Wire	AWS A5.17 AWS A5.23	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)			
					-20°C	-30°C	-40°C	-60°C
S2	F7A4-EM12	410	520	24	---	70	60	---
S2 Si	F7A4-EM12K	450	540	23	---	---	65	---
S2 Mo	F8A4-EA2-A2	480	570	27	---	---	70	---
S3 Si	F7A4-EH12K	490	580	26	---	---	60	---
S3 NiMo1	F9A4-EF3(mod)-F3	580	650	21	100	---	60	---
S3NiCrMo2.5	F11A8-EM4(mod.)-M4	740	850	20	90	---	85	min.27

Chemical Composition of Weld Metal - % (Typical)

Saw Wire	C	Si	Mn	Mo	Ni	Cr
S2	0.05	0.20	1.00	---	---	---
S2 Si	0.06	0.30	1.10	---	---	---
S2 Mo	0.07	0.25	1.15	0.45	---	---
S3 Si	0.10	0.60	1.70	---	---	---
S3 NiMo 1	0.09	0.25	1.65	0.55	0.90	---
S3 NiCrMo 2.5	0.06	0.30	1.50	0.50	2.20	0.50

Features and Applications

- This is fluoride-basic agglomerated flux
- This flux is suitable for welding high strength low alloy steels
- Prefable to use with wire electrodes having higher manganese level
- Recommended for multi-pass welding, in particular when there are high toughness requirement
- Process requirement of re-drying at 300°C - 350°C for 2 hours

Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800012	25	Kraft Bag

Approvals: ELIFLUX BFF: CE, SEPRO • S2Si x ELIFLUX BFF: BV, ABS, CE
 S3Si x ELIFLUX BFF: BV, ABS, CE • S2Mo x ELIFLUX BFF: DNV-GL, BV, ABS, CE
 S3NiCrMo2.5 x ELIFLUX BFF: ABS, CE

Submerged Arc Welding Flux

ELIFLUX BMS

Standards

TS EN ISO 14174	: SA CS/MS 1 68 AC
EN ISO14174	: SA CS/MS 1 68 AC
AWS A5.17	: F6AO-EM12 / F6AZ-EL12

Basicity
1.0

Mechanical Properties

SAW Wire	AWSA5.17	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)	
					0°C	-20°C
S1	F6AZ-EL12	395	475	24	38	---
S2	F6AO-EM12	390	485	30	---	69

Chemical Composition of Weld Metal - % (Typical)

SAW Wire	C	Si	Mn
S1	0.05	0.80	1.10
S2	0.04	0.45	1.27

Features and Applications

- A type of SAW flux structured from agglomerated manganese silicate and calcium silicate
- Basicity of the flux according to Boniszewski formula is 1,0
- Weld beads of excellent surface appearance and with easily removed slags
- High resistance to porosity caused by oil and rust
- High capacity of current flow
- Suitability for use in 2-pass welding operations on thick materials (best choice for base metals in thicknesses of 10-40 mm)
- Requirement of re-drying at 250-350°C for 2 hours

Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800009	25	Kraft Bag

Approvals: S2 / ELIFLUX BMS: BV, ABS, CE

ELIFLUX BMS: CE, SEPRO

Submerged Arc Welding Flux

ELIFLUX BSS-A

Standards

TS EN ISO 14174	: SA FB 2 65 DC
EN ISO 14174	: SA FB 2 65 DC

Basicity
2.45

Mechanical Properties

SAW Wire	Standards	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)		
				0°C	-110°C	-196°C
ELOX UP 307	ER 307	---	---	---	---	---
ELOX UP 308L	ER 308 L	550	41	70	50	40
ELOX UP 309L	ER 309 L	540	35	---	---	---
ELOX UP 316 L	ER 316 L	570	39	60	50	40

Chemical Composition of Weld Metal - % (Typical)

Saw Wire	C	Si	Mn	Mo	Cr	Ni	P	S
ELOX UP 307	---	---	---	---	---	---	---	---
ELOX UP 308 L	0.03	0.54	1.57		19.20	9.30	0.018	0.009
ELOX UP 309 L	0.03	0.40	1.63	0.03	24.20	13.10	0.017	0.008
ELOX UP 316 L	0.03	0.40	1.73	2.13	19.00	11.20	0.025	0.008

Features and Applications

- A type of fluoride basic flux for SAW
- General use in submerged welding of stainless steel materials
- Very high corrosion resistance
- Very good mechanical properties
- Formation of easily-removable slags
- Requirement of re-drying at 300-350°C for 2 hours

Operating Data

Product Code	Package Weight (Kg)	Package Type
6010800014	25	Kraft Bag

Approvals: CE, SEPRO

Submerged Arc Welding Flux

ELIFLUX BSS-D

Standards

TS EN ISO 14174	: SA FB 2 65 DC
EN ISO 14174	: SA FB 2 65 DC

Basicity
2.45

Mechanical Properties

SAW Wire	AWS A5.9	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))
ELOX UP 2209	ER 2209	830	32

Chemical Composition of Weld Metal - % (Typical)

Saw Wire	C	Si	Mn	Mo	Cr	Ni
ELOX UP 2209	0.03	0.90	1.85	3.15	21.15	8.50

Features and Applications

- A type of fluoride basic flux for SAW. General use in submerged welding of stainless steel materials
- The corrosion resistance and mechanical properties are good
- Formation of easily-removable slags
- Requirement of re-drying at 250°C - 350°C for 2 hours

Operating Data

Product Code	Package Weight (Kg)	Package Type
6010800007	25	Kraft Bag

Approvals: GeKa ELIFLUX BSS-D; CE, SEPRO
GeKa ELOX UP 2209 x ELIFLUX BSS-D; CE, CLASS NK

Submerged Arc Welding Flux

ELIFLUX BSS-F

Standards

TS EN ISO 14174	: SA FB 1 / SA FB 2 77 AC
EN ISO 14174	: SA FB 1 / SA FB 2 77 AC

SAW Wire	Standards	Hardness (HRC)* (as welded)
SUBCOR 41 NiMo - MH	AWS A5.22: ~ EC 410 NiMo	44

* Weld Thickness: 5 mm

Chemical Composition of Weld Metal - % (Typical)

Saw Wire	C	Si	Mn	Mo	Cr	Ni
SUBCOR 41 NiMo-MH	0.13	1.00	2.00	1.00	12.50	2.50

Features and Applications

- Non-alloyed, fluoride - basic agglomerated flux
- Used in hardfacing cladding for ferritic stainless steel with SUBCOR 41 NiMo-MH.
Also suitable for joint welding
- All the properties of the wire is transferred to weld pool. Hardness will very depending on it
- Suitable for overlay welding with oscillation and single/multi-pass welding
- Formation of easily removable slag
- Re-drying at 300°C - 350°C/2h

Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800015	25	Kraft Bag

Approvals: CE, SEPRO

ELIFLUX 350

Standards

TS EN ISO 14174	: SA FB 2 C Cr H5
EN ISO 14174	: SA FB 2 C Cr H5

Mechanical Properties

SAW Wire	Hardness (HB)
S1	300

* It is recommended to contact the manufacturer regarding the application.

Chemical Composition of Weld Metal - % (Typical)

SAW - Wire	C	Si	Mn	Cr	Fe
S1	0.10-0.30	0.50-1.00	1.00-1.80	1.60-3.00	Rest

Features and Applications

- A type of SAW flux structured from agglomerated calcium silicate
- This submerged arc welding powder and wire specification is used for hardfacing of steels
- Requirement of re-drying at 250°C - 350°C for 2 hours

Operating Data

Product Code	Package Weight (Kg)	Packaging
6010800012	25	Kraft Bag

Approvals: ELIFLUX 350: CE, SEPRO

По вопросам продаж и поддержки обращайтесь:

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