

WBSAWF-B1 SUB ARC FLUX

Classifications	AWS A5.17 : F7A2-EM12K AWS A5.17 : F6 A4 – EM12 F7 A8 – F7 P8 – EH12K DIN 32 522 : B FB 165 AC 12 MHP5 EN760 : A AB 1 67 AC H 5							
Wire Specifications	WBS1Si : AWS A5.17 F7A2-EL12K / BSEN 756 : S1Si WBS2Si : AWS A5.17 F7A2-EM12K / BSEN 756 : S2Si WBS3Si : AWS A5.23 F7A8-EG-G, F7P8-EG-G							
Product Description	WBSAWF-B1 is an agglomerated fluoride-basic sub arc flux.							
Applications	WBSAWF-B1 is an agglomerated fluoride-basic flux most suited to weld medium-tensile steels. The neutral behaviour of WBSAWF-B1 in terms of silicon and manganese pick-up and burn off is suited for both WBS1Si, WBS2Si and WBS3Si type wires. The flux has been developed for welding with twin or multi-wire processes. The flux can be welded on DC and AC. Basicity to Boniszewski : ~1.5 Packed in 25Kg plastic bags or 220Kg steel drums.							
Main Constituents of flux	CaO + MgO		Al₂O₃ + MnO		SiO₂ + TiO₂		CaF₂	
	30%		25%		20%		20%	

Typical All-Weld Chemical Analysis	C	Si	Mn	Mo	Cr	Ni
WBS1Si	0.07-0.15	0.15-0.40	0.80-1.15	-	-	-
WBS2Si	0.07-0.15	0.15-0.40	0.80-1.30	-	-	-
WBS3Si	0.05-0.08	0.25-0.40	1.30-1.50	-	-	-

Mechanical Test Properties	PWHT	UTS (N/mm²)	Yield (N/mm²)	EI (%)	C-V (J)	C-V (J)
WBS1Si	As-welded	480-530	>350	>22	>40 (-20°C)	-
WBS2Si	As-welded	480-530	>380	>22	>40 (-20°C)	-
WBS3Si	As-welded	540-640	>450	>25	>100(-20°C)	>70 (-40°C)

Storage and Re-Drying	<p>Storage It is recommended that the WB range of sub arc fluxes are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.</p> <p>Re-drying Re-dry @ 350°C for 2 hours and then transfer to holding oven and hold @ 100 - 200°C.</p>
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