



## WBSAWF-B1 SUB ARC FLUX

<b>Classifications</b>	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							
<b>Wire Specifications</b>	WBS1 : AWS A5.17 F7A2-EL12 / BSEN 14171-A : S1 WBS1Si : AWS A5.17 F7A2-EL12K / BSEN 14171-A : S1Si WBS2Si : AWS A5.17 F7A2-EM12K / BSEN 14171-A : S2Si WBS3Si : AWS A5.23 F7A8-EG-G, F7P8-EG-G							
<b>Product Description</b>	WBSAWF-B1 is an agglomerated fluoride-basic sub arc flux.							
<b>Applications</b>	<p>WBSAWF-B1 is an agglomerated fluoride-basic flux most suited to weld medium-tensile steels.</p> <p>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.</p> <p>The flux has been developed for welding with twin or multi-wire processes.</p> <p>The flux can be welded on DC and AC.</p> <p>Basicity to Boniszewski : ~1.5</p> <p>Packed in 25Kg plastic bags or 220Kg steel drums.</p>							
<b>Main Constituents of flux</b>	<b>CaO + MgO</b>		<b>Al<sub>2</sub>O<sub>3</sub> + MnO</b>		<b>SiO<sub>2</sub> + TiO<sub>2</sub></b>		<b>CaF<sub>2</sub></b>	
	30%		25%		20%		20%	

Typical All-Weld Chemical Analysis	C	Si	Mn	Mo	Cr	Ni
WBS1	0.05-0.09	0.10-0.20	0.45-0.75	-	-	-
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/mm <sup>2</sup> )	Yield (N/mm <sup>2</sup> )	EI (%)	C-V (J)	C-V (J)
WBS1	As welded	450-510	>350	>22	>40 (-20°C)	-
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)

<b>Storage and Re-Drying</b>	<p><b>Storage</b> 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><b>Re-drying</b> Re-dry @ 350°C for 2 hours and then transfer to holding oven and hold @ 100 - 200°C.</p>
------------------------------	---