

PREMIERWELD™ BF-1**CONFORMS TO**

- AWS A5.17: F7A4-EH14, F7A4-EM12K
- GB 12470: F5A4-H10Mn2, F5A4-H08MnA
- EN 760: S A FB 1

APPROVALS

- CCS: 4YM

APPLICATION

- Important Structural steel welding
- X52, X60 and X65 grade, Pipe steel welding
- Offshore
- Wind Tower

PRODUCT INFORMATION

- Fluoride-Basic type agglomerated flux
- Basicity Index: 1.8
- Density: 1.25 g/cm³
- Grain size: 10-60 Mesh
- Polarity: AC or DCEP

REDRYING

- Before welding operation, If moisture contamination is suspected from either improper storage condition or due to condensation, the flux must be redried as a 300 to 350°C for 2 hours.

PACKAGING

- 25 KG/Bag
- Please contact us for other package form

FLUX COMPOSITION - TYPICAL

CaO+MgO	Al ₂ O ₃ +MnO	SiO ₂ +TiO ₂	CaF ₂
28%	23%	21%	22%

PREMIERWELD™ BF-1**CLASSIFICATION**

Flux / Wire	AWS A5.17	GB 12470
PREMIERWELD™ BF-1 / PREMIERWELD™ H14	F7A4-EH14	-
PREMIERWELD™ BF-1 / PREMIERWELD™ M12K	F7A4-EM12K	-
PREMIERWELD™ BF-1 / PREMIERWELD™ HM-1	-	F5A4-H10Mn2
PREMIERWELD™ BF-1 / PREMIERWELD™ MM-1	-	F5A4-H08MnA

ALL WELD METAL CHEMICAL COMPOSITIONS (Wt.-%) TYPICAL

Flux / Wire	C	Mn	Si	P	S
PREMIERWELD™ BF-1 / PREMIERWELD™ H14	0.06	1.255	0.307	0.021	0.014
PREMIERWELD™ BF-1 / PREMIERWELD™ M12K	0.04	0.92	0.35	0.028	0.018
PREMIERWELD™ BF-1 / PREMIERWELD™ HM-1	0.058	1.692	0.303	0.019	0.013
PREMIERWELD™ BF-1 / PREMIERWELD™ MM-1	0.05	0.88	0.19	0.020	0.011

ALL WELD METAL MECHANICAL PROPERTIES TYPICAL

Flux / Wire	Condition	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Charpy V-Notch (J)		
					0°C	-20°C	-40°C
PREMIERWELD™ BF-1 / PREMIERWELD™ H14	As-Welded	450	565	32	--	--	140
PREMIERWELD™ BF-1 / PREMIERWELD™ M12K	As-Welded	415	509	31	--	--	80
PREMIERWELD™ BF-1 / PREMIERWELD™ HM-1	As-Welded	423	510	33	--	--	120
PREMIERWELD™ BF-1 / PREMIERWELD™ MM-1	As-Welded	411	495	32	--	--	95

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com.cn for any updated information.

Authorized Distributor:

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