

SSB

CLASSIFICATION

Flux | EN ISO14174: S A AF 2 DC

CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

Wire grade	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N	Nb	W
308S92	0.02	1.2	0.6	0.01	0.02	19.7	10		0.1			
347S96	0.03	1.2	0.6	0.01	0.02	19.2	10		0.1		0.5	
316S92	0.02	1.2	0.6	0.01	0.02	18.2	12	2.6	0.1			
309S92	0.03	1.5	0.6	0.01	0.02	24	12.5		0.1			
ER329N	0.02	1.3	0.5	0.01	0.02	22.5	8.5	3.1	0.1	0.15		
Zeron® 100X	0.02	0.6	0.4	0.01	0.02	24.5	9.3	3.6	0.7	0.21		0.7

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	308S92	347S96	316S92	309S92	ER329N	Zeron® 100X
Tensile strength (MPa)	570	630	570	600	790	890
0.2% Proof strength (MPa)	450	470	450	475	630	700
Elongation (%) 4d	41	35	41	35	30	25
Impact ISO-V (J) -130°C	50*		45			
-100°C		30				
-50°C				70	55	40

*For -196°C impact properties with austenitic stainless steel wires P2007 flux is preferred and batch testing of the selected wire-flux combination is recommended

FLUX CHARACTERISTICS

Current type	DC+
Basicity (Boniszewski)	~2.2

PACKAGING AND AVAILABLE SIZES

Packaging	Weight (kg)	Item number
BAG	25.0	SASSB

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.