

ES FLUX 171

SAW

ESWECO
The Art of Welding

Type Basic

EN 760: SA AB 1 66 AC H5

Description

ES FLUX 171 is a basic agglomerated, slightly Si- and Mn-alloying flux for submerged arc welding, specially designed for fillet welding and for the single- and multi-pass butt welding of mild, medium and high tensile steels. ES FLUX 171 is of the aluminate basic type and, for this slag system, it has a very high current-carrying capacity on both AC and DC and very good operating characteristics. ES FLUX 171 is ideally suited to narrow gap welding due to the excellent slag detachability and smooth side-wall blending.

Density

approx. 1.2 kg/dm³

Basicity index

1.6

Flux consumption, kg flux/kg wire

Voltage	DC+	AC
26	0.6	0.5
30	0.85	0.7
34	1.15	0.95
38	1.35	1.15

Typical all weld metal composition, %

Wire	C	Si	Mn	Cr	Ni	Mo
ES EA2	0.05	0.4	1.35	-	-	0.5
ES EA4	0.09	0.4	1.5	-	-	0.5

Typical mech. Properties all weld metal

Wire	Yield Stress MPa	Tensile strength MPa	Charpy V	
			°C	J
ES EA2	500	580	+20	125
			0	100
			-20	60
			-40	30
ES EA4	535	620	+20	120
			0	105
			-20	70
			-30	60
			-40	45

Classifications

Wire	EN 756	SFA/AWS A5.17
ES EA2	S 46 2 AB S2Mo	F8A2-EA2-A4/F7P0-EA2-A4
ES EA4	S 50 3 AB S3Mo	F8A4-EA4-A3/F8P2-EA4-A3