

## Agglomerated Welding Flux BF 8.13

**Flux type:** Calcium-Silicate

**Classification:** ISO 14174 – S A CS 3 CCrMo AC

BF 8.13 shows constant chemical reactions as typical for a Bavaria-alloyed flux.

**Characteristics:**

Agglomerated and active SAW flux (C, Cr, Mo alloying characteristic) designed for hardfacing, and joint welding of low alloyed wire electrodes.

**Further information on request.**

**Characteristic chemical Constituents:**

$\text{SiO}_2 + \text{Al}_2\text{O}_3 + \text{TiO}_2$	$\text{CaO} + \text{MgO}$	$\text{CaF}_2$
55 %	25 %	10 %
Basicity according to Boniszewski: ~1.7		

**Flux density:** 1.2–1.3 kg/dm<sup>3</sup> (l)

**Grain size acc. to ISO 14174:** 2–16 (Tyler 10×65)

**Current-carrying capacity:** 800 A DC using one wire 4.0 mm

**Packaging:** 25 kg PE-Bags, drums 25 kg

**Storage and redrying:** Unopened originally packed flux bags can be stored up to one year in dry storage rooms after date of delivery ex-factory.

**Redrying conditions specific to the flux:**  
150–200 °C effective flux temperature

**Chemical composition**

(characteristical values in wt. %)

Weld Metal	Wire	C	Mn	Si	Cr	Mo
1L	BA-S2	0.12	1.3	0.6	1.3	0.15
2L	BA-S2	0.12	1.5	0.7	1.7	0.20
3L	BA-S2	0.12	1.7	0.9	1.8	0.25

**Mechanical properties**

(characteristical values)

Wire	Heat treatment	Hardness
L1 – BA-S2	As welded	270 HB
L2 – BA-S2	As welded	330 HB
L3 – BA-S2	As welded	340 HB