

Select Ni4S

Low Alloy / Flux Shielded / Submerged Arc

PRODUCT DATA SHEET

FEATURES

- Contains additions of nickel and molybdenum to produce good low temperature toughness while maintaining a tensile strength that withstands heat treatment.
- Better control of bead penetration than solid wire
- Higher deposition rates than solid wire when run at the same current level
- Exhibits a broader and shallower bead profile than solid wire - reducing the tendency for burn through
- Capable of running directly over root passes with proper procedure - eliminating requirement for a hot pass
- Easy slag removal - reduces post weld clean up time
- Typical applications include pressure vessels, offshore oil equipment, bridges, and other structural applications
- Arcflux BF-10MW helps to maximize the impact properties and is the recommended flux. Other basic fluxes can be used as well.

CONFORMANCES

AWS A5.23

F8A8-ECNi4-Ni4 (ARCFLUX BF-10 MW)

F9A8-ECNi4-Ni4

F9P6-ECNi4-Ni4

DIAMETERS [in (mm)]

5/32 (4.0)

POSITIONS



FLUX

ARCFLUX BF-10MW

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY [WT%]

Flux	C	Cu	Mn	Mo	Ni	P	S	Si
ARCFLUX BF-10 MW	0.06	0.05	1.48	0.26	1.83	0.020	0.010	0.46

TYPICAL MECHANICAL PROPERTIES

Flux	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp	CVN @ -60°F (-50°C) ft-lb (J)	CVN @ -80°F (-60°C) ft-lb (J)
ARCFLUX BF-10 MW	102 (703)	91 (627)	26	As-Welded	-	43 (58)	32 (43)
ARCFLUX BF-10 MW	99 (683)	87 (597)	26	PWHT	1150°F for 1 hr	26 (35)	-



Notice: Be sure to follow all your employers safety practices, policies and procedures when using this product. Refer to CSA W117.2 and ANSI Z49.1 Safety in Welding, Cutting and Allied Processes for further information and the manufactures SDS sheet. The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Flux	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
5/32 (4.0 mm)	ARCFLUX BF-10 MW	Flat & Horizontal	50 (1.3)	450	30	1 - 1 1/4 (25 - 32)
		Flat & Horizontal	65 (1.7)	550	31	1 - 1 1/4 (25 - 32)
		Flat & Horizontal	80 (2.0)	650	32	1 - 1 1/4 (25 - 32)

*WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance

**The parameters listed are recommended starting points of operation and the ranges for amperage, wfs, and voltage could be extended based on fitness for application. For products with "all-position" capability, as determined and listed in classification, the position recommendation can be determined based on operator skill and material thickness and isn't limited to the listing.

PACKAGING (lbs (kgs))

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

**Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.*

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.



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