

STAINLESS STEEL AND NICKEL-BASE CORED WIRES FOR LASTING CONNECTIONS – ARTICLE NUMBERS

Böhler Welding offers stable, reliable and consistent high-quality cored wires. Produced in Europe, they are fulfilling both EN ISO and AWS codes choosing the most stringent requirements.

Advantages of our flat and horizontal wires

- » Self-releasing slag
- » Very low spatter formation
- » High deposition rates result in high productivity
- » Smooth weld profiles with finely rippled surface pattern
- » Easy to handle with fantastic parameter range
- » Wide arc ensures good wetting with even penetration and side-wall fusion



Fillet weld in flat position (PB / 2F).
The base material is AISI 304L and the filler Avesta FCW-2D 308L/MVR (E308LT0-4/1).
Ø1.2 mm (.045").



Cladding with Böhler CN 23/12 Mo-FD (E309LMoT0-4/1) for the 1st and BÖHLER EAS 4 M-FD (E316LT0-4/1) for the 2nd layer. Results in very uniform ferrite levels.

Advantages of our all-position wires

- » Genuine T1 wires – one parameter setting for complete welding job
- » Excellent impact toughness and corrosion resistance
- » Increased superior deposition rate with thicker sheath
- » Wires form thin well-covering slag, with good detachability
- » Best possible recovery rate with superior efficiency
- » Run with 2 m/min (79 in/min) higher wire feeding
- » Increased welding speed and productivity save time and money
- » Reduced number of weld passes needed
- » Keep heat input down, minimize distortion and emit less fumes
- » Good arc stability and high intensity for improved side-wall fusion
- » Safety to porosity formation and slag inclusions
- » Very clean melt
- » Pass x-ray radiographic testing
- » Little demand for cleaning and pickling and no need to clean spatter



Seawater pump in UNS S32205 duplex stainless steel welded using Avesta FCW 2507/P100-PW (E2594T1-4/1) for highest possible corrosion resistance.



Mechanized welding of LNG storage tanks with BÖHLER NIBAS 625 PW-FD (ENiCrMo3T1-4).

Products supplied on plastic spools*

AWS A5.22	Product name	0.9 mm (.035")	1.2 mm (.045")	1.6 mm (1/16")
Soft-martensitic stainless flux-cored wire				
E410Ni-MoT1-4/1	BÖHLER CN 13/4-PW			86482
Standard austenitic stainless flux-cored wires				
E308LT0-4/1	Avesta FCW-2D 308L/MVR		15745	15751
E308LT1-4/1	Avesta FCW 308L/MVR-PW	15739	15746	15755
E316LT0-4/1	Avesta FCW-2D 316L/SKR		16969	16980
E316LT1-4/1	Avesta FCW 316L/SKR-PW	16965	16981	16982
E347T0-4/1	BÖHLER SAS 2-FD		17310	
E347T1-4/1	BÖHLER SAS 2 PW-FD		17314	17392
"E318T0-4/1"	BÖHLER SAS 4-FD		17399	
"E318T1-4/1"	BÖHLER SAS 4 PW-FD		17402	
E317LT0-4/1	BÖHLER E 317L-FD		17420	17431
E317LT1-4/1	BÖHLER E 317L PW-FD		17422	
Austenitic stainless flux-cored wires for special applications				
E307T0-4/1	BÖHLER A 7-FD		17117	17118
E307T1-4/1	BÖHLER A 7 PW-FD		17224	17248
E309LT0-4/1	Avesta FCW-2D 309L		16827	16829
E309LT1-4/1	Avesta FCW 309L-PW	16445	16828	16837
E309LMoT0-4/1	BÖHLER CN 23/12 Mo-FD		17114	17115
E309LMoT1-4/1	BÖHLER CN 23/12 Mo PW-FD	21683	17116	
Austenitic stainless flux-cored wires for low temperature applications				
E308LT1-4/1	Avesta FCW 308L/MVR Cryo		17403	
E347T1-4/1	BÖHLER SAS 2 PW-FD (LF)		17398	
E316LT1-4/1	BÖHLER EAS 4 PW-FD (LF)		17404	
Duplex stainless flux-cored wires				
E2307T0-4/1	Avesta FCW-2D LDX 2101		16987	
E2307T1-4/1	Avesta FCW LDX 2101-PW		16988	
E2209T0-4/1	Avesta FCW-2D 2205		17029	30086
E2209T1-4/1	Avesta FCW 2205-PW		17050	24754
E2209T1-4/1	BÖHLER CN 22/9 PW-FD (S)		17065	
E2594T1-G	Avesta FCW LDX 2404-PW		17003	
E2594T1-4/1	Avesta FCW 2507/P100-PW		17099	
E2594T1-4/1	Avesta FCW 2507/P100-PW NOR		17101	

AWS A5.22	Product name	1.2 mm (.045")	1.6 mm (1/16")
Austenitic Bi-free stainless flux-cored wires for high-temperature and creep resistant steels and cladding			
	BÖHLER E 308 H-FD	17405	17408
E308HT1-4/1	BÖHLER E 308 H PW-FD	17406	
E309LT0-4/1	BÖHLER E 309L H-FD	17410	
E309LT1-4/1	BÖHLER E 309L H PW-FD	17413	
E347T0-4/1	BÖHLER E 347L H-FD	17416	
E347HT1-4/1	BÖHLER E 347 H PW-FD	17419	
Soft-martensitic stainless metal-cored wires			
EC410NiMo (mod.)	BÖHLER CN 13/4-MC	57902	57903
EC410NiMo (mod.)	BÖHLER CN 13/4-MC HI	80181	
EC410NiMo (mod.)	BÖHLER CN 13/4-MC (F)	57852	
Ferritic stainless metal-cored wires			
EC439	BÖHLER CAT 439L Ti-MC	84378	
EC439Nb	BÖHLER CAT 430L Cb-MC	78396	
EC439Nb	BÖHLER CAT 430L CbTi-MC	78399	
Standard austenitic stainless metal-cored wires			
EC308L	BÖHLER EAS 2-MC	17469	
EC316L	BÖHLER EAS 4 M-MC	17471	
Austenitic stainless metal-cored wires for special applications			
EC307 (mod.)	BÖHLER A 7-MC	17462	17467
EC309L	BÖHLER CN 23/12-MC	17472	
EC309H (mod.)	BÖHLER FF-MC	17468	

AWS A5.34	Product name	1.2 mm (.045")	1.6 mm (1/16")
Nickel-base flux-cored wires			
ENiCr-Mo3T1-4	BÖHLER NIBAS 625 PW-FD	17432	17435
ENiCr3T0-4	BÖHLER NIBAS 70/20-FD	17441	17448
ENiCr3T0-4 (mod.)	BÖHLER NIBAS 70/20 Mn-FD	17460	

* All products on high-quality plastic spools apart from ferritic stainless steel metal-cored wires and all soft-martensitic products.