



Cored Wires for Joining

The complete range of Flux Cored & Metal Cored Wires

High Alloyed Steels

Flux Cored Wires

Austenitic Steels	BÖHLER Welding Product	EN ISO	AWS
AISI 304 L	BÖHLER EAS 2-FD	T 19 9 L R M21 (C1) 3	E308LT0-4(1)
	BÖHLER EAS 2 PW-FD	T 19 9 L P M21 (C1) 1	E308LT1-4(1)
	Avesta 308L/MVR Cryo	T 19 9 L P M21 (C1) 1	E308LT1-4(1)
	Thermanit 308L-PW	T 19 9 L P M21 (C1) 1	E308LT1-4(1)
AISI 316 L	BÖHLER EAS 4 M-FD	T 19 12 3 L R M21 (C1) 3	E316LT0-4(1)
	BÖHLER EAS 4 PW-FD	T 19 12 3 L P M21 (C1) 1	E316LT1-4(1)
	Avesta FCW 316L/SKR CRYO	T 19 12 3 L P M21 (C1) 1	E316LT1-4(1)
	Thermanit 316 L-PW	T 19 12 3 L P M21 (C1) 1	E316LT1-4(1)
AISI 347 L	BÖHLER SAS 2-FD	T 19 9 Nb R M21 (C1) 3	E347T0-4(1)
	BÖHLER SAS 2 PW-FD	T 19 9 Nb P M21 (C1) 1	E347T1-4(1)
	BÖHLER SAS 2 PW-FD (LF)	T 19 9 Nb P M21 (C1) 1	E347T1-4(1)
	Avesta FCW-2D 347/MVNB	T 19 9 Nb R M21 (C1) 3	E347T0-4(1)
AISI 316 Cb	BÖHLER SAS 4-FD	T 19 12 3 Nb R M21 (C1) 3	-
	BÖHLER SAS 4 PW-FD	T 19 12 3 Nb P M21 (C1) 1	-
AISI 317 L	BÖHLER E 317 L-FD	T Z19 13 4 L R M21 (C1) 3	E317LT0-4(1)
	BÖHLER E 317 L PW-FD	T Z19 13 4 L P M21 (C1) 1	E317LT1-4(1)
Duplex Steels			
Duplex	BÖHLER CN 22/9 N-FD	T 22 9 3 NL R M21 (C1) 3	E2209T0-4(1)
	BÖHLER CN 22/9 PW-FD	T 22 9 3 NL P M21 (C1) 1	E2209T1-4(1)
	Avesta 2205-PW	T 22 9 3 NL P M21 (C1) 1	E2209T1-4(1)
Lean Duplex	Avesta FCW 2D-LDX 2101	T Z24 9 N L R M21 (C1) 3	E2307T0-4(1)
	Avesta FCW LDX 2101-PW	T Z24 9 N L P M21 (C1) 1	E2307T1-4(1)
	Avesta 2304-PW	T Z24 9 N L P M21 (C1) 1	E2307T1-4(1)
Super Duplex	Avesta FCW 2507/P100-PW	T 25 9 4 N L P M21 (C1) 2	E2594T1-4(1)
	Avesta FCW 2507/P100-PW NOR	T 25 9 4 N L P M21 (C1) 2	E2594T1-4(1)
Special Applications			
Dissimilar Joints	BÖHLER A 7-FD	T 18 8 Mn R M21 (C1) 3	E307T0-G
	BÖHLER A 7 PW-FD	T 18 8 Mn P M21 (C1) 2	E307T1-G
	BÖHLER CN 23/12-FD	T 23 12 L R M21 (C1) 3	E309LT0-4(1)
	BÖHLER CN 23/12 PW-FD	T 23 12 L P M21 (C1) 1	E309LT1-4(1)
	Avesta FCW 309-L	T 23 12 L R M21 (C1) 3	E309LT0-4(1)
	Thermanit TG 309L	T 23 12 L R M21 (C1) 3	E309LT0-4(1)
	BÖHLER E 309L H PW-FD	T 23 12 L P M 1	E309LT1-4
	BÖHLER CN 23/12 Mo-FD	T 23 12 2 L R M21 (C1) 3	E309LMoT0-4(1)
	Avesta FCW 2D-P5	T 23 12 2 L R M21 (C1) 3	E309LMoT0-4(1)
	BÖHLER CN 23/12 Mo PW-FD	T 23 12 2 L P M21 (C1) 1	E309LMoT1-4(1)
High-temperature and Creep Resistant Steels			
AISI 304 H	BÖHLER E 308 H-FD	T Z19 9 H R M21 (C1) 3	E308HT0-4(1)
	BÖHLER E 308 H PW-FD	T Z19 9 H P M21 (C1) 1	E308HT1-4(1)
	Avesta FCW 308H-PW	T Z19 9 H P M21 (C1) 1	E308HT1-4(1)
AISI 347, AISI 321	BÖHLER E 347 H PW-FD	T 19 9 Nb P M 1	E347HT1-4
Nickel Based Materials			
Alloy 600	BÖHLER NIBAS 70/20-FD	T Ni 6082 R M21 3	ENiCr3T0-4
	BÖHLER NIBAS 70/20 Mn-FD	T Ni 6083 R M21 3	ENiCr3T0-4
	UTP AF 068 HH	T Ni 6082 R M21 3	ENiCr3T0-4
	UTP AF 068 HH MN	T Ni 6083 R M21 3	ENiCr3T0-4
Alloy 625	BÖHLER NIBAS 625 PW-FD	T Ni 6625 P M21 2	ENiCrMo3T1-4
	UTP AF 6222 MOPW	T Ni 6625 P M21 2	ENiCrMo3T1-4

Metal Cored Wires

Austenitic Steels	BÖHLER Welding Product	EN ISO	AWS
AISI 304 L	BÖHLER EAS 2-MC	T 19 9 L M M12 2	EC308L
AISI 316 L	BÖHLER EAS 4 M-MC	T 19 12 3 L M M12 2	EC316L
	AVESTA MCW 316L/SKR	T 19 12 3 L M M12 2	EC316L
Softmartensitic Steels			
13/4 CrNi Steels	BÖHLER CN 13/4-MC	T 13 4 M M12 2	EC410NiMo
	BÖHLER CN 13/4-MC (F)	T 13 4 M M12 2	EC410NiMo
Special Applications			
Dissimilar Joints	BÖHLER A 7-MC	T 18 8 Mn M M12 1	EC307
	BÖHLER CN 23/12-MC	T 23 12 L M M12 1	EC309L
AISI 430	BÖHLER CAT 430 L Cb Ti-MC	T Z17 Nb Ti L M M12 (M13) 1	EC430G / EC439Nb

General Benefits when welding with BÖHLER Welding cored wires

- High economic benefits with Böhler flux cored wires due to a high deposition rate, combined with a high deposition efficiency leads to a significant reduction of total welding costs:
 - less wire consumption per kg weld metal
 - less welding time
 - less spatter, less cleaning time
- Excellent weld ability especially with our Positional Welding wires (pos. PF)
- Wide range of applications: thin plates from 0.6 mm with metal core wire up to 100 mm with flux cored wire dia. 1.6 mm



Unalloyed Steels

Unalloyed Steels	BÖHLER Welding Product	EN ISO	AWS
Flux Cored Wire	BÖHLER Ti 52-FD	T 46 4 P M 1 H10 / T 42 2 P C 1 H5	E71T1-M21A4-CS1-H8 / E71T1-C1A2-CS1-H4
	BÖHLER Ti 52 W-FD	T 46 4 P M 1 H10 / T 42 2 P C 1 H5	E71T1-M21A4-CS1-H8 / E71T1-C1A2-CS1-H4
	BÖHLER Ti 52 T-FD	T 46 4 P M 1 H5 / T 46 2 P C 1 H5	E71T1-M21A4-CS1-H4 / E71T1-C1A2-CS1-H4
	Union TG 55 M	T 46 4 P M 1 H10 / T 42 2 P C 1 H5	E71T1-M21A4-CS1-H8 / E71T1-C1A2-CS1-H4
	BÖHLER Kb 52 T-FD	T 46 4 B M 3 H5 / T 42 4 B C 3 H5	E70T5-M21A4-CS1-H4 / E70T5-C1A4-CS1-H4
Metal Cored Wire	BÖHLER HL 46-MC	T 46 2 M M 1 H5	E70C-6MH4
	BÖHLER HL 51 T-MC	T 46 6 M M 1 H5 / T 42 5 M C 1 H5	E70T15-M21A8-CS1-H4 / E70T15-C1A6-CS1-H4
	Union TG 55 FE	T 46 4 M M 1 H5	E70C-6MH4
	BÖHLER HL 46 GS T-MC	T 46 Z M 1 H5	E70T15-M21AZ-CS1-H4
Self Shielded	BÖHLER Ti 52 NG T-FD	T 46 Z Y N 1	E71T11-AZ-CS3-H8
Flux Cored Wire			
High Strength Steels			
Flux Cored Wire	BÖHLER Ti 60-FD	T 50 6 1Ni P M 1 H5	E81T1-M21A8-Ni1-H4
	BÖHLER Ti 60 T-FD	T 50 6 1Ni P M 1 H5 / T 46 4 1Ni P C 1 H5	E81T1-M21A8-Ni1-H4 / E81T1-C1A4-Ni1-H4
	BÖHLER Ti 70 Pipe-FD	T 55 4 Mn1Ni P M 1 H5	E91T1-M21A4-G
	BÖHLER Ti 70 Pipe T-FD	T 55 5 Mn1Ni P M 1 H5	E91T1-M21A6-K2-H4
	BÖHLER Ti 80 T-FD	T 69 6 Z P M 1 H5	E111T1-M21A8-GH4
	BÖHLER Ti 2 Ni T-FD	T 46 6 2Ni P M 1 H5	E81T1-M21A8-Ni2-H4
	BÖHLER Kb 65 T-FD	T 55 4 1NiMo B M 3 H5	E90T5-M21A4-GH4
	BÖHLER Kb 85 T-FD	T 69 6 Mn2NiCrMo B M 3 H5	E110T5-M21A8-K4-H4
Self Shielded	BÖHLER Pipeshield 71 T8-FD	-	E71T8-A4-K6
Flux Cored Wire	BÖHLER Pipeshield 71.1 T8-FD	-	E71T8-A4-Ni1
	BÖHLER Pipeshield 81 T8-FD	-	E81T8-A4-Ni2
Metal Cored Wire	BÖHLER ALFORM 700-MC	T 69 5 Mn2NiCrMo M M 1 H5	E110C-K4H4
	BÖHLER ALFORM 900-MC	T 89 2 ZMn2NiCrMo M M 1 H5	E120C-GH4
	BÖHLER ALFORM 960-MC	T 89 4 ZMn2NiCrMo M M 1 H5	E120C-GH4
	BÖHLER HL 53 T-MC	T 50 6 1Ni M M 1 H5	E80T15-M21A8-Ni1-H4
	BÖHLER HL 65 T-MC	T 55 4 1NiMo M M 1 H5	E90T15-M21A4-K1-H4
	BÖHLER HL 75 T-MC	T 62 4 Mn1NiMo M M 2 H5	E101T15-M21A4-G-H4
	BÖHLER NiCu1 T-MC	T 46 6 Z M M 1 H5	E80T15-M21A8-GH4
Creep Resistant Steels			
Flux Cored Wire	BÖHLER DMO Ti-FD	T MoL P M 1 H10	E81T1-M21PY-A1H8
	BÖHLER DMO Kb T-FD	T 46 6 Mo B M 3 H5	E80T5-M21P8-A1-H4
	BÖHLER DCMS Ti-FD	T CrMo1 P M 1 H10	E81T1-M21PY-B2H8
	BÖHLER DCMS Kb T-FD	T CrMo1 B M 3 H5	E80T5-M21PY-B2-H4
	BÖHLER CM 2 Ti-FD	T CrMo2 P M 1 H10	E91T1-M21PY-B3-H8
	BÖHLER CM 2 Kb T-FD	T CrMo2 B M 3 H5	E90T5-M21PY-B3-H4
	BÖHLER DCMV Kb T-FD	T Z B M 3 H5	E90T5-M21PY-GH4
	BÖHLER CM5 Kb T-FD	T CrMo5 B M 3 H5	E80T5-M21PY-B6-H4
	BÖHLER CB 2 Ti-FD	T ZCrMoCo9VNbNB P M 1	E91T1-GM
	BÖHLER C 9 MV Ti-FD	T ZCrMo9VNb P M 1	E91T1-M21PY-B91
	BÖHLER P 92 Ti-FD	T ZCrWMo9VNb P M 1	E91T1-M21PZ-B92
Metal Cored Wire	BÖHLER DMO T-MC	T 46 2 Mo M M 1 H5	E80T15-M21P0-A1-H4
	BÖHLER DCMS T-MC	T CrMo1 M M 1 H5	E80T15-M21PY-B2-H4
	BÖHLER CM 2 T-MC	T CrMo2 M M 1 H5	E90T15-M21PY-B3-H4
	BÖHLER C 9 MV-MC	T 69T15-1G-9C1MV	E90C-B9



BÖHLER Welding Flux Cored Wire in Action



Welding of a double-walled heated tube for the plastic processing industry. The base material is 1.4541 and the used welding consumables are BÖHLER EAS 2-FD and BÖHLER EAS 2 PW-FD for out of position welds. (BÖHLER EAS 2-IG TIG rods were used for the root pass).



This application is typical for our high efficiency PW – wires for positional welding. This refiner for the paper industry is too big to be manipulated – therefore welding out of position is necessary!

Welding of very thin tubes like this part of a car exhaust (0.6 mm) is a very critical application – perfect for welding with BÖHLER Welding Metal Cored Wires, which are suitable for such special demands.

Welding on a big case of a steam-turbine made of cast steel COST CB2.

Welding consumable:
BÖHLER CB 2 Ti-FD





BÖHLER Welding consumables for all joining applications and processes

Böhler Welding provides not only the broadest product range of cored wires worldwide with over 80 flux cored and metal cored types in folded and seamless technology, but also the complete range of:

- SMAW – Stick electrodes
- TIG wires
- MIG/MAG wires
- SAW wires and fluxes
- Gas welding rods

With over 80 years of experience accumulated globally, we provide our customers and partners proven solutions for their daily operational welding challenges and ensure lasting connections. Convince yourself of the high quality of our products and take advantage of the economic benefits.



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