

## **SUBARC T55 HP: Improved submerged arc welding productivity from new cored wire**

**Filler metal specialist Böhler Welding has introduced BÖHLER SUBARC T55 HP - a seamless, copper-coated cored wire developed for the submerged arc welding of unalloyed and fine-grained structural steels up to a yield strength of 460 MPa.**

It has a series of advantages over solid wire which, together, represent a great potential for a reduction of total SAW welding costs and project lead times. Applicability and obtainable savings strongly depend on the SAW application and a thorough analysis is needed to assess feasibility, in which Böhler Welding specialists can support interested fabricators.

BÖHLER SUBARC T55 HP is a basic cored wire which is specially formulated to fully benefit from the increased deposition rate brought along by the cored wire design. In combination with three different fluxes – UV 421 TT, UV 400 and UV 306 – it forms cored wire / flux combinations for a variety of applications. It allows substantially higher welding currents in butt welding and higher travel speeds in fillet welding in situations where a higher heat input is acceptable. Alternatively users can opt for a lower heat input at the same deposition rate / travel speed or any other desired balance. The basic flux formulation brings reserve in terms of strength and CVN impact toughness to compensate for the bigger weld beads and fewer layers that come along with the increased deposition rates.

Increased welding productivity and lower total welding costs are further promoted by important side-effects such as dependable weld penetration and tie-in, easier slag release and lower flux consumption, lower defect rates and lower contact tip. The SUBARC T 55 HP wire / flux combinations can be applied in single wire, tandem wire and twin wire SAW systems.

A fact sheet in English can be downloaded from <http://www.voestalpine.com/welding>

For a printed copy, please contact [welding.gcc@voestalpine.com](mailto:welding.gcc@voestalpine.com) with your name and postal address.

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## **voestalpine Böhler Welding**

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### **About us**

#### **voestalpine Böhler Welding**

Is a leading manufacturer and worldwide supplier of filler metals for industrial welding and brazing applications. As a part of the voestalpine Group, one of the world's leading suppliers of specialized steel products, voestalpine Böhler Welding is part of a global network of metallurgy experts. With more than 100 years of experience, the enterprise has decisively influenced the development of welding technology, setting the benchmark with its innovative solutions. With its three areas of competence – Böhler Welding for joint welding, UTP Maintenance for repair and maintenance welding and Fontargen Brazing for soldering and brazing – outstanding solutions for all challenging welding projects in demanding industries are offered. Read more on [www.voestalpine.com/welding](http://www.voestalpine.com/welding)

#### **Metal Engineering Division**

The voestalpine Metal Engineering Division is the global market leader in turnout technology and complete rail systems, and is the European market leader in special rails and quality wire. The division is also a leading provider of seamless tubes and high-quality welding consumables. Customer segments include the railway infrastructure industry, the oil and gas industry, the steel and construction industry, as well as the mechanical engineering and automotive industries. In the business year 2015/16, the division and its Steel, Rail Technology, Wire Technology, Tubulars, Turnout Systems, and Welding Consumables business units generated revenue of more than EUR 2.85 billion, of which around 43% was generated outside of Europe. The division, with its approximately 12,700 employees worldwide, reported an operating result (EBITDA) of EUR 385 million.

#### **The voestalpine Group**

The voestalpine Group is a steel-based technology and capital goods group that operates worldwide. With around 500 Group companies and locations in more than 50 countries and on all five continents, the Group has been listed on the Vienna Stock Exchange since 1995. With its top-quality products, the Group is one of the leading partners to the automotive and consumer goods industries in Europe and to the oil and gas industries worldwide. The voestalpine Group is also the world market leader in turnout technology, special rails, tool steel, and special sections. In the business year 2015/16, the voestalpine Group reported revenue of EUR 11.1 billion and an operating result (EBITDA) of EUR 1.6 billion; it had around 48,500 employees worldwide.

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ONE STEP AHEAD.