Solid Wire Electrode for Submerged Arc Welding

BA-S2NiCu

Classification:
EN ISO 14171-A (EN 756) – **S2Ni1Cu**
SFA-5.23 / AWS A5.23 – **EG / (EW mod.)**

Typical analysis and chemical composition acc. to EN ISO 14171-A and AWS A5.23: (Weight Percent)

Wire electrode	C	Si	Mn	Mo	Ni	Cr	P	S	Cu total
Typical analysis BA-S2NiCu	0.10	0.23	0.98	0.04	0.78	0.07	0.012	0.010	0.48
S2Ni1Cu acc. to ISO 14171-A	0.08–0.12	0.15–0.35	0.70–1.20	0.15	0.65–0.90	0.40	0.020	0.020	0.40–0.65
EW acc. to AWS A5.23	0.12	0.20–0.35	0.35–0.65		0.40–0.80	0.50–0.80	0.025	0.030	0.30–0.80

Characteristics:
NiCu-alloyed wire electrode for submerged arc welding of weathering steels and special structural steels in steel construction as well as plant and bridge construction.

Base Materials:
- Weathering steels and special structural steels: S235JRW, S235J2G3Cu, S355J2G1W, S355J2G3Cu and Corten A, Patinax 37
  Suitable fluxes: BF 3, BF 4, BF 5.1, BF 6.5 and BF 10

Flux type suitability is strongly dependent on its application. In combination with the wire electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

Package forms:
Coils, spools, drums and spiders as standard package forms for SAW-wire electrodes, different package forms on request.

Diameter:
2.0 – 5.0 mm; Sizes and tolerances acc. to ISO 544 and AWS A5.23.

Wire electrode surface:
Copper-coated, smooth finish free from surface defects and foreign matter.