

## Solid Wire Electrode for Submerged Arc Welding

**Classification:**

ISO 14171-A -  
SFA 5.23 / AWS A5.23 -

**S2MoTiB**  
**EA2TiB**

**Characteristics:**

Wire electrode for submerged arc welding with Ti and B to achieve optimum impact properties with the two-run technique with pipe-mill fluxes . Exclusively for as-welded applications.

**Typical analysis and chemical composition acc. to EN ISO 14171-A and AWS A5.23:**

Wire electrode	C	Si	Mn	Mo	P	S	Ti	B	Cu total
Typical analysis BA-S2MoTiB	0.08	0.20	1.25	0.54	0.015	0.015	0.14	0.012	0.10
BA-S2MoTiB acc. to ISO 14171-A	0.05-0.15	0.15-0.35	1.00-1.35	0.40-0.65	0.025	0.025	0.10- 0.20	0.005- 0.020	0.30
EA2TiB acc. to AWS A5.23	0.05-0.17	0.35	0.95-1.35	0.45-0.65	0.025	0.025	0.05- 0.30	0.005- 0.030	0.35

**Base Materials:**

- According to EN 10208-2/ISO 3183: L360 – L555
- According to API 5L: grades X52 – X80  
Suitable fluxes: BF 6 .5, BF 6 .30

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.

**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.

**Package forms:**

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