Solid Wire Electrode for Submerged Arc Welding

Classification:
ISO 14171-A - **SZ**
SFA 5.23 / AWS A5.23 - **EG**

Characteristics:
Mo-alloyed wire electrode with higher Mn-content and micro alloying additions Ti/B for submerged arc welding in the two-run technique of pipe steels for high toughness requirements also at low temperatures at –46 °C or below.

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

Wire electrode	C	Si	Mn	Mo	Ni	Cr	P	S	Others
Typical analysis BA-S3MoTiB	0.08	0.30	1.25	0.50	0.02	0.03	0.008	0.004	Ti 0.15 B 0.015 Cu 0.05
SZ acc. to ISO 14171-A	0.10	0.15-0.35	1.30-1.60	0.45-0.65	0.15	0.10	0.015	0.010	Ti 0.10-0.18 B 0.010-0.018 Cu 0.30
EG acc. to AWS A5.23	0.10	0.15-0.35	1.30-1.60	0.45-0.65	0.15	0.10	0.015	0.010	Ti 0.10-0.18 B 0.010-0.018 Cu 0.30

Base Materials:

- Pipe steels acc. to ISO 3183, EN 10208 and API-5: L415M/X60 to L555M/X80
  Suitable fluxes for spiral welding: BF 6.30 and BF 6.5
  Suitable fluxes for longitudinal welding: BF 6.30 and BF 6.3

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.