Solid Wire Electrode for Submerged Arc Welding

Classification:
ISO 14171-A - **S3Ni1,5Mo**
SFA 5.23 / AWS A5.23 - **EF1**

Characteristics:
NiMo-alloyed wire electrode with higher Mn-content for submerged arc welding of high tensile fine grain steels in vessel and apparatus constructionand and high tensile pipe steels.

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	CU total
Typical analysis BA-S3NiMo1,5	0.11	0.17	1.62	0.41	1.48	0.05	0.011	0.004	0.10
S3Ni1,5Mo acc. to ISO 14171-A	0.07-0.15	0.05-0.25	1.20-1.80	0.30-0.50	0.20-1.80	0.20	0.020	0.020	0.30
EF1 acc. to AWS A5.23	0.07-0.15	0.15-0.35	0.90-1.70	0.25-0.55	0.95-1.60		0.025	0.025	0.35

Base Materials:

- Fine grain steels acc. to EN 10025, EN 10028: P460N/S460NL to S550QLQuenched and tempered steels such as N-A-XTRA 70, 20MnMoNi5-5, HY80
  Suitable fluxes: BF 5.1, BF 6.5 and BF 10

- Pipe steels acc. to ISO 3183, EN 10208 and API-5: L485Q/X70 to L555Q/X80
  Suitable fluxes: BF 6.30 and BF 6.5

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.