

Solid Wire Electrode for Submerged Arc Welding

Classification:

ISO 14341-A -
SFA 5.17 / AWS A5.17 -

G3Si1
EH11K

Characteristics:

Wire electrode with higher Si- and Mn-content for submerged arc welding of pipe steels with low Si- and Mn- content.

Typical analysis and chemical composition acc. to AWS A5.17:

Wire electrode	C	Si	Mn	Mo	Ni	Cr	P	S	Cu total
Typical analysis BA-S3Si1	0.09	0.95	1.67	0.06	0.04	0.03	0.012	0.009	0.04
EH11K acc. to AWS A5.17	0.06-0.15	0.80-1.15	1.40-1.85				0.030	0.030	0.35

Base Materials:

- Pipe steels acc. to ISO 3183, EN 10208 and API-5: L360N/X52 to L485Q/X70
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 A5.17.

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.