

## Solid Wire Electrode for Submerged Arc Welding

**Classification:**

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

**SZ**  
**EG**

**Characteristics:**

Wire electrode for submerged arc welding intended for welding pipeline steel . Developed for multi-wire welding with two-run technique, for applications in sour gas service . Exclusively for as-welded applications.

**Typical analysis:**

Wire electrode	C	Si	Mn	Mo	Ni	Cr	P	S	Ti	B	N	Cu total
Typical analysis BA-S3TiB	0.07	0.25	1.65	0.003	0.02	0.03	0.009	0.005	0.115	0.011	0.0030	0.01

**Base Materials:**

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

**Diameter:**

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

**Wire electrode surface:**

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.