Solid Wire Electrode for Submerged Arc Welding

Classification:
ISO 14171-A - **S4Mo**
SFA 5.23 / AWS A5.23 - **EA3**

Characteristics:
Mo-alloyed wire electrode with high Mn-content for submerged arc welding in the two-run technique of fine grain steels, pipe steels and heat-resistant boiler and vessel 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-S4Mo	0.12	0.11	1.90	0.50	0.05	0.06	0.016	0.013	0.09
S4Mo acc. to ISO 14171-A	0.07-0.15	0.05-0.25	1.75-2.25	0.45-0.65	0.15	0.15	0.025	0.025	0.30
EA3 acc. to AWS A5.23	0.05-0.17	0.20	1.65-2.20	0.45-0.65			0.025	0.025	0.35

Base Materials:

- Fine grain steels acc. to EN 10025, EN 10028 and ASTM: P460N/S460NL to P500Q/S500QL
  Suitable fluxes: BF 5.1 and BF 6.5
- Pipe steels acc. to ISO 3183, EN 10208 and API-5: L360N/X52 to L555Q/X80
  Suitable fluxes: BF 5.1, BF 6.30 and BF 6.5
- Heat-resistant steels acc. to EN 10028 and ASTM: 16 Mo 3/A204 grade A and A209 grade T1,
  Suitable flux: BF 10

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.