

S1

CATEGORY SAW Submerged arc

CLASSIFICATION
 AWS A 5.17: EL 12
 EN ISO 14171-A: S1
 DIN 8575: S1

SUITABLE FOR Unalloyed steels: St 33 – St 52 Ship building: A, E, AH, EH Boiler steels: HI-HIII, 17Mn4, Pipe steels: St 37.0/4 – St 52.0/4 Fine-grain steels: StE 255 – StE 420

APPROVALS CE approved

WELDING POSITIONS:



C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al
0.06-0.10	0.35-0.60	< 0.10	< 0.025	< 0.025	< 0.15	< 0.15	< 0.15	< 0.30	< 0.03

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	kg / spool / drum	kg / 6pack	kg / 1000
3,2			25 / -		
4,0			25 / 350		
4,8			25 / 350		

REDRYING TEMPERATURE Not required