

CATEGORY	SAW Arc Submerged
TYPE	Solid wire for submerged arc welding up to 420 MPa yield strength structural steels
APPLICATIONS	Shipbuilding, piping, root welding, bridges, repair, construction, offshore, etc.
PROPERTIES	Solid drawn and rolled SAW wire with copper coating for improved current carrying capacity. S2 wire can be used with FL 180, FL188, FL 155 and FL 851 depending on the requirements and application.

CLASSIFICATION	AWS	A 5.17: EM12K
	AWS	A 5.23: EM12K
	EN ISO	14171-A: S2Si
	F-nr	6
	FM	1

SUITABLE FOR	A, B, D, E, St 37 - St 52-3, DIN 17 100, H I, H II, 17Mn4, 16Mo5, DIN 17 155, StE 255 - StE 355, DIN 17 102, GS-38, GS-60, DIN 1681, St 35.8, St 45.8, DIN 17 175, St 37.0 - St 52.0, DIN 1626 / 1629, St 37.4 - St 52.4, DIN 1628 / 1630, StE 290.7 TM - StE 360.7 TM, DIN 17 172, X 52
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APPROVALS	CE
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WELDING POSITIONS:	
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TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)					
C	Si	Mn	P	S	
0.1	0.3	1.1	0.015	0.015	

ALL WELD MECHANICAL PROPERTIES					
Heat Treatment	R <sub>p0.2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	0°C	Impact Energy (J) ISO-V -20°C
As Welded /1h	460	600	22	60	50

WELDING PARAMETERS / PACKING	
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REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175	
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