UP S2Ni1

Low Alloy Submerged Arc Wire

Classification

AWS A 5.23: ERNi1 Material N: 1.6222
ENISO 24598A: S2Ni1

Charateristics

Solid copper coated Wire for submerged arc welding, For welding of steels where impact properties are required at -60°C.

Applications

Applications include structural, oil and gas and offshore steel work. For cryogenic construction steels and Ni bearing steels.
11MnNi5-3, 13MnNi6-3, S275NL-S460NL, S275ML-S460ML, P275NL2-P460NL2, P355ML2-P460ML2
ASTM: A333/A334 grades 1/6, A350 grades LF2/LF6, A352 grades LCB/LCC , API: 5L X65

Typical Wire Composition (%)

C	Si	Mn	Ni	Ti + Zr+ V	Cu	P	S
0.08	0.30	1.30	0.95	<0.05	0.15	0.020	0.010

All Weld Metal Mechanical Properties

Conditions	UTS Rm (MPa)	YS $R_{p0.2}$ (MPa)	% Elg A=5d	Impact (kv) Temp. ˚C J
AW UP BF 10	540	445	24	- 80 40

Parameters

Process	Wire Ø (mm)	Current (A)	Voltage (V)	Travel Speed (cm/min)	Flux
UP/SAW DC +ve	2.40	200 - 400	25 – 28	45 – 55	UP LA 04 UP LA05 UP BF10
	3.20	300 - 500	25 – 28	45 – 55	
	4.00	500 - 700	28 – 32	45 – 55	

Packing & Storage

25 kg Spool packed in Corrugated Cardboard Boxes. Wire to be Stored in dry conditions.

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