AS S2Mo

Submerged Arc Welding Wire for Low Alloyed Steels

Classification

EN ISO 14171 : S2 Mo (L-223 ile S 46 4 AB S2Mo)
AWS A5.23 : EA2

General Description

AS S2 Mo is copper coated submerged arc welding wire designed particularly for the welding of high impact resistant steels.

Chemical Composition (w%), Typical, Wire

C	Si	Mn	Mo
0.10	0.10	1.00	0.50
0.06 *	0.25 *	1.30 *	0.50 *

(*) Typical weld metal composition with flux LW 223

Approvals (with flux LW-223)

GOST, SEPRO, TSE, TÜV

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 460 - 600 N/mm²
Tensile Strength : 550 - 670 N/mm²
Impact (ISO-V) : 50 J (–20°C)

with flux LincolnWeld 223 : Yield Strength : 470 N/mm²
Tensile Strength : 550 N/mm²
Elongation (L=5d) : 29 %
Impact (ISO-V) : 55 J (–20°C)

Note : Tensile and Yield Strength values are given in a wide range, as the submerged arc welding flux compositions might vary considerably.

Materials to be Welded

	DIN	EN
General Structural Steels	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52, St 52-3	S185, S235, S275, S355
Fine Grained Steels	StE 255 - StE 460 WStE 255 - WStE 460	S255N - S460N P255NH - P460NH
Pipe Materials	StE 320-7 - StE 415-7 StE 290-7 TM - StE 480-7 TM X42, X46, X52, X56, X60, X65, X70, X80 (API 5LX)	L320 - L415NB L290MB - L485MB –
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 5, 15 Mo 3 HI, HII, HIII	P295GH, P310GH, 16 Mo 3 P235GH, P265GH, P285NH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH

Packing and Diameter Informations

Diameter	2.0	2.4	3.2	4.0	Spool Weight	Drum Weight
Submerged Arc Welding Wire	-	-	X	X	25 kg	350 / 650 kg