AS S2Si

Submerged Arc Welding Wire for Mild Steels

Classification

EN ISO 14171 : S2 Si (L-761 ile S 46 2 MS S2Si)
AWS A5.17 : EM12K

General Description

AS S2 Si is copper coated submerged arc welding wire designed particularly for the welding of middle and high strength steels.

Chemical Composition (w%), Typical, Wire

C	Si	Mn	S
0.07	0.15	1.00	0.025
0.07 *	0.65 *	1.70 *	0.025 *

(*) Typical weld metal composition with flux LincolnWeld 761

Approvals (with flux LW-761)

GOST, NAKS, SEPRO

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 370 - 440 N/mm²
Tensile Strength : 450 - 530 N/mm²
Impact (ISO-V) : 47 J (– 20°C)

with flux LincolnWeld 761 : Yield Strength : 430 N/mm²
Tensile Strength : 560 N/mm²
Impact (ISO-V) : 47 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 St 50.2, St 60.2, St 70.2	S185, S235, S275, S355 E295, E335, E360
Fine Grained Steels	StE 255 - StE 460 WStE 255 - WStE 460	S255N - S460N P255NH - P460NH
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 6 HI, HII, HIII St 37.2, St 44	P295GH, P310GH P235GH, P265GH, P285NH P235S, P265S
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, B, C, D AH32 - EH36	– –

Packing and Diameter Informations

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