



NOUVARC S1 + ASK 70S

Submerged Arc Welding Wires & Fluxes

AWS/SFA A 5.17

F7A2 +EL8

Characteristics

High quality flux for welding mild steel and medium tensile steel with mechanical properties and X-ray quality welding properties. Self detachability with combination of our SAW wire.

Drying Requirements

Re baking is recommended at 300°C for one hour

Applications

Pen stock shells, pressure vessels. Earth moving equipments, structural, off shore plat forms, blast furnace shells and boilers where UTS upto 540 N/mm² specified also for machine building, Locomotives, Rail Girders, Crane Girders etc.,

Typical End Chemistry of Weld Metal

C%	Mn%	Si%	S%	P%
0.07	1.20	0.35	0.025 max	0.030 max

Mechanical Properties of Our Weld Metal

UTS (Mpa)	YS (Mpa)	ELONG %	CVN - 20°C
520 min	430 min	26 min	35J

[Values obtained with good operating conditions]

Applicability

Current : 1000 Amps Max
Voltage : 27 - 32 V
Polarity : AC/DC +

Packing Particulars

Diameter of Wire : 2.0 mm / 2.5 mm / 3.15 mm /
4.0mm / 5.0 mm
Our packing norms 25 Kg wire
250 Kg & 500 Kg Drums
25 Kg Flux/Bag (Atm shield)
100 Kg Drum

ISO 9001 Certified Company

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