



# NOUVARC S6

## Submerged Arc Welding Wires & Fluxes

**AWS/SFA A 5.23**

**F7A0-EA2**

### Characteristics

Manganese-Silicate type of Submerged arc welding flux with high current carrying capacity. It is active flux with high Si and Mn Pick-up. This is particularly suited for single and multi-wire welding at high Speed. Due to the active nature of the flux it has high restraint cracking resistance.

### Drying Requirements

Re baking is recommended at 300°C for one hour

### Applications

Best suited for High-Speed butt-welding applications. Welding speeds of 2m/min are possible. Particularly suited for twin wire, tandem and Multiwire welding at relatively high speed : Pipe Mills - Spiral and longitudinal welding

### Typical End Chemistry of Weld Metal

C%	Mn%	Si%	S%	P%	Mo%
0.07	1.20	0.35	0.03 max	0.03 max	0.45

### Mechanical Properties

UTS (Mpa)	YS (Mpa)	ELONG %	CVN - 40°C
550 min	460 min	26 min	30J

### 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

25 Kg Flux/Bag (Atm shield)  
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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