

NOUVARC S6

Submerged Arc Welding Wires & Fluxes

AWS/SFA A 5.23
F7AO-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

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 : In mm 2.0 | 2.5 | 3.15 | 4.0 | 5.0

Packing Norms

Wire : 25 Kg
Flux/ Bag* : 25 Kg
Drum : 100 / 250 / 500 Kgs

*Atm shield