

NOUVARC S6

ASME SFA-5.23/SFA-5.23M EA2

UNS No: K11223

DESCRIPTION:

- NOUVARC S6 Submerged Arc Solid Wire suitable for welding of high tensile fine grain steel as well as steel which required high ductility.
- The weld metal has good elevated temperature properties and improved corrosion resistance features.

APPLICATION:

- NOUVE S-EA2 is suitable for welding of various structural & Pressure vessel steels.
- Main areas of application are associated with steam generating power plant, piping and boiler super heaters.

CHEMICAL COMPOSITION OF SOLID ELECTRODE (wt%) :

ELEMENTS	AWS SPEC	TYPICAL
Carbon (C)	0.05 - 0.17	0.10
Manganese (Mn)	0.95 - 1.35	1.15
Phosphorus (P)	0.025 Max.	0.010
Sulphur (S)	0.025 Max.	0.012
Silicon (Si)	0.20 Max.	0.15
Copper (Cu)	0.35 Max.	0.20
Molybdenum (Mo)	0.45-0.65	0.52

NOUVARC S6

ASME SFA-5.23/SFA-5.23M EA2

UNS No: K11223

MECHANICAL PROPERTIES OF DEPOSITED METAL:

MECHANICAL TESTS	TYPICAL
Tensile Strength	600 Mpa
Yield Strength	520 Mpa
Elongation	28 %
Impact Energy @-30°C	75 J

RECOMMENDED WELDING TECHNIQUES:

Current/Polarity : DCEP

SIZE (mm)	AMPERAGE (A)	VOLTAGE (V)
2.50	320-100	26-30
3.20	350-450	28-30
4.00	400-550	28-32
5.00	550-650	28-32

PACKING:

SIZE (mm)	WINDING MODE	PACKING MODE	WEIGHT (kgs.)
2.50	RING	CORRUGATED BOX	25.0
3.20	RING	CORRUGATED BOX	25.0
4.00	RING	CORRUGATED BOX	25.0
5.00	RING	CORRUGATED BOX	25.0