

NOUVARC S7

ASME SFA-5.23/SFA-5.23M EA4

UNS No: K11424

DESCRIPTION:

- NOUVARC S7 Submerged Arc Solid Wire is a manganese-alloyed, copper coated wire for the submerged arc welding of medium and high strength structural steels.
- The weld metal has good elevated temperature properties and improved corrosion resistance features.

APPLICATION:

- NOUVARC S7 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)	0.05-0.15	0.07
Manganese (Mn)	1.20-1.70	1.50
Phosphorus (P)	0.025 Max.	0.010
Sulphur (S)	0.025 Max.	0.015
Silicon (Si)	0.20 Max.	0.015
Copper (Cu)	0.35 Max.	0.15
Molybdenum (Mo)	0.45-0.65	0.50

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MECHANICAL PROPERTIES OF DEPOSITED METAL:

MECHANICAL TESTS	TYPICAL
Tensile Strength	620 Mpa
Yield Strength	530 Mpa
Elongation	29 %
Impact Energy @-20°C	92 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	25.0/30.0
3.20	RING	CORRUGATED BOX	25.0/30.0
4.00	RING	CORRUGATED BOX	25.0/30.0
5.00	RING	CORRUGATED BOX	25.0/30.0