



S1,S2,S4

Copper coated solid wires for mild steel submerged arc welding

Mild steel wires for use in combination with agglomerated submerged arc fluxes.

International Standards

	BS EN 756:2004	AWS A5.17- 97
S1	S1	EL12
S2	S2	EM12
S4	S4	EH14

Typical Wire Analysis (wt%)

	C	Si	Mn	S	P
S1	0.08	0.10	0.50	0.006	0.005
S2	0.09	0.08	1.05	0.005	0.009
S4	0.12	0.08	1.90	0.011	0.014

Mechanical Properties

Dependant upon flux wire combination.

Materials

S1	S185, P235GH, P265GH, P235G1TH – P255G1TH
S2	S275JR – S355JO, P235GH, P256GH, P285NH, P310GH, P255G1TH
S4	S275JR-S355JO, E335, P285NH, P310GH, S355JOCu

Packaging

Size mm	1.6	2.4	3.2	4.0
25 kilo coil	✓	✓	✓	✓
250 kilo Pops	✓	✓	✓	✓

Additional Information

Certification	BS EN 10204:2004 Type 3.1
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