



S2Mo, S3Mo, S2 1Ni and S3 1Ni 1/2Mo

Copper coated solid wires for Low alloy submerged arc welding

Low alloy wires for use in combination with fully basic submerged arc fluxes.

International Standards

	BS EN 756:2004	AWS A5.17 and 23
S2Mo	S2 Mo	EA2
S3Mo	S3 Mo	EA4
S2 1Ni	S2Ni1	ENi1
S3 1Ni 1/2 Mo	S3 Ni 1Mo	EF3

Typical Wire Analysis (wt%)

	C	Si	Mn	Ni	Mo
S2Mo	0.09	0.15	1.05	-	0.52
S3Mo	0.12	0.15	1.52	-	0.52
S2 1Ni	0.10	0.10	1.00	0.9	-
S3 1Ni 1/2 Mo	0.11	0.17	1.40	0.9	0.55

Mechanical Properties

Dependant upon flux wire combination.

Materials

S2Mo	S355JO, E355, P285NH, P310GH S355JOCu, 16MO3, P315N-S420N, P315NH-P420NH
S3Mo	S550GD, E355, P285NH, P310GH, S355JOCu, 16M03, P315N-S420N, P315NH-P420NH
S2 1Ni	S380N – S500N, P380NH – P500NH, S380NL – S500NL
S3 1Ni 1/2 Mo	S690QL1, 10CrMo9-10

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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