

# NOUVARC S1

ASME SFA-5.17/SFA-5.17M EL8

## DESCRIPTIONS:

- NOUVARC S1 is Copper-coated mild steel solid wire for welding of mild and medium carbon structural steels, unalloyed steels in combination with agglomerated SAW flux.

## APPLICATIONS:

- NOUVARC S1 wire is ideally suited for welding of single-pass or multiple-pass welding for structural steel, offshore platforms, Ships, and Pressure vessels.

## CHEMICAL COMPOSITION OF FILLER METAL (wt%) :

ELEMENTS	AWS SPEC	TYPICAL
Carbon (C)	0.10 max	0.06
Manganese (Mn)	0.25-0.60	0.54
Silicon (Si)	0.07 max	0.05
Sulphur (S)	0.03 Max.	0.014
Phosphorus (P)	0.03 Max.	0.012
Copper (Cu)	0.35 Max.	0.12

# NOUVARC S1

ASME SFA-5.17/SFA-5.17M EL8

## RECOMMENDED WELDING TECHNIQUES:

Current/Polarity : DCEP  
 Recommended flux : NOUVE

SIZE (mm)	AMPERAGE (A)	VOLTAGE (V)	TRAVEL SPEED (mm/s)
1.60	250-350	26-29	4.5-5.5
2.00	300-400	26-29	5.5-6.5
2.50	350-450	27-30	5.5-6.5
3.15	425-525	27-30	6.0-7.0
4.00	475-575	27-30	6.5-7.5
4.80	525-625	27-30	6.5-7.5
5.00	550-650	27-30	6.5-7.5

## PACKING:

SIZE (mm)	WINDING MODE	PACKING MODE	WEIGHT (kgs.)
1.60	SPOOL/DRUM PACK/WIRE BASKET	CORRUGATED BOX/PAPER DRUM/WIRE BASKET	15.0/700
2.50	RING/DRUM PACK/WIRE BASKET	CORRUGATED BOX/PAPER DRUM/WIRE BASKET	25/700
3.15	RING/DRUM PACK/WIRE BASKET	CORRUGATED BOX/PAPER DRUM/WIRE BASKET	25,30/700
4.00	RING/DRUM PACK/WIRE BASKET	CORRUGATED BOX/PAPER DRUM/WIRE BASKET	25,30/700
4.80	RING/DRUM PACK/WIRE BASKET	CORRUGATED BOX/PAPER DRUM/WIRE BASKET	25,30/700
5.00	RING/DRUM PACK/WIRE BASKET	CORRUGATED BOX/PAPER DRUM/WIRE BASKET	25,30/700