

NOUVARC S2

ASME SFA-5.17/SFA-5.17M EM12K

DESCRIPTIONS:

- NOUVARC S2 is used for submerged arc welding applications. Excellent for wide range of applications with single or multi pass welding. This wire consists of low carbon, medium manganese and low silicon. In combination with below listed Flux.

APPLICATIONS:

- NOUVARC S2 is recommended for joint welding of general and fine grained structural steels, windmill towers, shipbuilding steels, bridge constructions, pressure vessels and pipe steels .

CHEMICAL COMPOSITION OF FILLER METAL (wt%) :

ELEMENTS	AWS SPEC	TYPICAL
Carbon (C)	0.05-0.15	0.08
Manganese (Mn)	0.80-1.25	1.01
Silicon (Si)	0.10-0.35	0.18
Sulphur (S)	0.03 Max.	0.010
Phosphorus (P)	0.03 Max.	0.007
Copper (Cu)	0.35 Max.	0.15

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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