

## S2 1NiCrMo

**CATEGORY** SAW Arc Submerged

**TYPE** Solid wire for submerged arc welding process for welding HSLA structural steels

**APPLICATIONS** Heavy construction, lifting, platforms, jackups, towers, crane building, machinery, riser pipes etc.

**PROPERTIES** High strength weld deposit with good post weld heat treatment properties. S2 1NiCrMo can be used in combination with [FL 851](#) and [FL 155](#), both fluxes offer low hydrogen content and excellent weldability in multi layer welding and narrow gap.

**CLASSIFICATION** AWS 5.23: EG  
EN ISO 14171-A: S2 1NiCrMo

**SUITABLE FOR** X80, AISI 4130, 8630, ASME: ASTM A302 Grade B, ASTM A336 Grade F30, ASTM A487 Class 1N, 1Q 2N, 2Q, 4130  
EN: S(P)460-S(P)555

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	Cr	Ni	Mo
0.12	1.0	0.27	1.0	0.95	0.57

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>760	840-870	>24		>40		
PWHT 660°C/3hr	>590	690-720	>25		>27		

AW: as welded , PWHT: post weld heat treated

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spooling type	kg / spool / drum
2.0			K-435 / Drums	20-30 / 300
2,4			K-435 / Drums	20-30 / 300
3,2			K-435 / Drums	20-30 / 300
4,0			K-435 / Drums	20-30 / 300

**REDRYING TEMPERATURE** not required