

## Low alloy solid wire

### Classification

|                  |          |
|------------------|----------|
| AWS A5.23/A5.23M | EG       |
| EN 756           | S2 Ni1Cu |

### General description

Submerged arc wire with Cu and Ni addition dedicated to weathering steel assembly like Cor-Ten grades

Matching corrosion resistance as well as color

To be used with 960 flux in most of the applications

Can be used in butt welds single run or multi runs as well as in fillet welds

### Approvals

|     |     |
|-----|-----|
|     | TÜV |
| 860 | X   |

### Chemical composition (w%) typical wire

| C   | Mn | Si   | Cu  | Ni  | Cr     | S & P   |
|-----|----|------|-----|-----|--------|---------|
| 0.1 | 1  | 0.25 | 0.5 | 0.7 | 0,2max | 0,02max |

### Packaging and available sizes

| Unit type              | Diameter (mm) |     |     |     |     |
|------------------------|---------------|-----|-----|-----|-----|
|                        | 2.0           | 2.4 | 3.2 | 4.0 | 4.8 |
| 25 kg Stein basket     | X             | X   | X   | X   | X   |
| 100 kg Stein basket    | X             | X   | X   | X   |     |
| 350 kg Speed Feed drum |               | X   |     |     |     |
| 400 kg Speed Feed drum | X             | X   | X   | X   |     |
| 1000 kg Accutrak® Drum | X             | X   | X   | X   |     |

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**Liability:** All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request