

## Union S 2

SAW Wire

### Classifications

unalloyed

EN ISO 14171

AWS A5.17

S2

EM12

### Characteristics and field of use

General structural steels up to S355JR, boiler plates up to P295GH, shipbuilding steels, pipe steels up to L360 and unalloyed boiler tubes, fine grained structural steels up to P355N, S355N.

### Base materials

ASTM A36 Gr. all; A106 Gr. A, B; A214; A242 Gr. 1-5; A266 Gr. 1, 2, 4; A283 Gr. A, B, C, D; A285 Gr. A, B, C; A299 Gr. A, B; A328; A366; A515 Gr. 60, 65, 70; A516 Gr. 55; A556 Gr. B2A; A570 Gr. 30, 33, 36, 40, 45; A572 Gr. 42, 50; A606 Gr. all; A607 Gr. 45; A656 Gr. 50, 60; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A841; A851 Gr. 1, 2; A935 Gr. 45; A936 Gr. 50;

### Typical analysis of the wire (Wt-%)

| C   | Si  | Mn  |  |  |
|-----|-----|-----|--|--|
| 0,1 | 0,1 | 1,0 |  |  |

### Available flux

*Flu* : UV 420 TT, UV 421 TT, UV 418 TT, UV 306, UV 400.

### Operating data



Polarity =  $\pm$

### Dimensions (mm)

|     |     |     |     |
|-----|-----|-----|-----|
| 2,0 | 2,5 | 3,0 | 4,0 |
|-----|-----|-----|-----|