

IANCO S2 1NiCrMo

SAW wire for low alloy steels

Product name	IABCO S2 1NiCrMo
Classification EN ISO	14171-A / 26304-A: SZ
Material No.	-
Classification AWS	A5.23: EG
Approvals	-
Applications	Submerged arc welding wire for high strength quenched and tempered steels. Applications will be found in the offshore industry, shipbuilding, pressure vessels, earthmoving equipment, cranes and general structural fabrication.
Base materials	For high strength low alloy steels with yield strength up to 690MPa (100ksi). ASTM: A514, A517. HY80, HY100, Q1(N). S500Q-S690Q, S500QL-S690QL, P500Q-P690Q, P500QL1-P690QL1.
Typical analysis of wire, weight %	C: 0.10 Si: 0.25 Mn: 1.10 Ni: 0.95 Cr: 1.00 Mo: 0.55
Typical heat treatment ⁽¹⁾	Welding procedure (including preheat temperature, interpass temperature and PWHT) will be dependent on the base material being welded, including its thickness, and any applicable design codes.
Mechanical properties of weld deposit ⁽²⁾	Mechanical properties will be dependent on the welding procedure and flux.
Other products	MIG/GMAW: FK 1/FK 2/FK 800. TIG/GTAW: FK 1.

Notes (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.