

## IABCO S2Ni1

### SAW wire for low alloy steels

Product name	IABCO S2Ni1
Classification EN ISO	14171-A: S2Ni1
Material No.	1.6222
Classification AWS	A5.23: ENi1
Approvals	TÜV 12686.00, CE.
Applications	Submerged arc welding wire for steels where impact properties are required at -50°C. Applications include structural, oil & gas and offshore steelwork.
Base materials	For cryogenic construction steels and Ni bearing steels. ASTM: A333/A334 grades 1/6, A350 grades LF2/LF6, A352 grades LCB/LCC. API: 5L X65 11MnNi5-3, 13MnNi6-3, S275NL-S460NL, S275ML-S460ML, P275NL2-P460NL2, P355ML2-P460ML2.
Typical analysis of wire, weight %	C: 0.10 Si: 0.10 Mn: 1.00 Ni: 0.90
Typical heat treatment <sup>(1)</sup>	Preheat and PWHT are often not necessary but actual requirements will depend on the grade and thickness of material being welded and any design codes that apply.
Mechanical properties of weld deposit <sup>(2)</sup>	Mechanical properties will be dependent on the welding procedure and flux.
Other products	MIG/GMAW: ER80S-Ni1. TIG/GTAW: ER80S-Ni1.

**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.