

## IABCO S2MoTiB

### SAW wire for pipemills

Product name	IABCO S2MoTiB
Classification EN ISO	14171-A: S2MoTiB
Material No.	-
Classification AWS	A5.23: EA2TiB
Approvals	-
Applications	Submerged arc welding of pipeline steel. Optimised for multi arc welding using DSAW (two-run) technique. For applications in sour gas service.
Base materials	Low alloy wire with Ti & B additions optimised for multi-arc welding using a two run technique. API: 5L grades X52-X80. EN 10208-2: L360-L555.
Typical analysis of wire, weight %	C: 0.08 Si: 0.25 Mn: 1.15 Mo: 0.52 Ti: 0.14 B: 0.011
Typical heat treatment <sup>(1)</sup>	Preheat and interpass temperature requirements will be dependent on specific process, procedure and code requirements. Ti-B micro-alloyed weld deposits are left in the as-welded condition.
Mechanical properties of weld deposit <sup>(2)</sup>	Mechanical properties will be dependent on the flux, weld procedure and base material composition.
Other products	SAW: IABCO S3½MoTiB, IABCO S3MoTiB.

**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.