

WELDING POSITIONS : 

- Copper Coated, Low Carbon / Manganese Steel SAW Wire
- For General Purpose Submerged Arc Welding Applications

Approval	
Lloyds Register Of Shipping	Grade 3,3YH10
American Bureau Of Shipping	Grade 3H10, 3Y

### DESCRIPTION AND APPLICATIONS

POWERWELD S1 is a copper coated, nominal 0.5% Mn solid steel wire, suitable for a whole range of submerged arc fillet / butt welding and hard surfacing application. POWERWELD S1 wire is very low in deoxidant, must be used with agglomerated saw flux.

TYPICAL WIRE ANALYSIS (Wt%)			
C	Mn	Si	Fe
0.08	0.5	0.01	Bal

OPERATIONAL AND PACKAGING DATA			
WIRE SIZE (mm)	CURRENT RANGE (amps)	PACKAGING (kg)	
		COIL	BULK REEL
2.0	200-480	25 / 30	450 / 700
2.4	250-550	25 / 30	450 / 700
3.2	330-600	25 / 30	450 / 700
4.0	410-750	25 / 30	450 / 700

- These current ranges are given as a guide only. They may be exceeded in specific application when used with a suitable flux.