

# STRONG ENI1

CLASSIFICATION: AWS SFA 5.23 ENi1

SAW Wire for Cryogenic Steel applications



## CHARACTERISTICS & APPLICATIONS

STRONG ENi1 is a Nickel alloyed, copper coated wire for the Submerged Arc Welding of high strength steels where impact properties are required at negative temperatures. The weld metal will provide good impact properties at -60 degree Celsius. Especially suitable for welding of pipes and tubes of matching compositions in power plants, refineries, petrochemicals, fertilizers plants etc.

## TYPICAL WIRE CHEMISTRY (%)

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.12 MAX	0.75- 1.25	0.05- 0.30	0.020 MAX	0.020 MAX	0.15 MAX	0.75- 1.25	0.30 MAX	0.35 MAX

## PACKAGING SPECIFICATIONS - SAW SPOOL PACK

DIA SIZE	1.60MM / 2.00MM / 2.40MM / 3.15MM / 4.00MM / 5.00MM
SPOOL WEIGHT	25KGS / 30KGS

## PACKAGING SPECIFICATIONS - DRUM PACK

DIA SIZE	1.60MM / 2.00MM / 2.40MM / 3.15MM / 4.00MM / 5.00MM
WEIGHT	150KGS / 250KGS / 300KGS / 350KGS / 500KGS

## RECOMMENDED COMBINATION SAW FLUX

WIRE SIZE 2.40MM AND ABOVE	STRONG FLUX 10G / STRONG FLUX 62
WIRE SIZE 2.40MM AND BELOW	STRONG FLUX 16HS