

STRONG ENI3

CLASSIFICATION: AWS SFA 5.23 ENi3

SAW Wire for Cryogenic Steel applications



CHARACTERISTICS & APPLICATIONS

STRONG ENi3 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 have 3.50% Ni deposition and 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
0.13 MAX	0.60- 1.22	0.05- 0.30	0.020 MAX	0.020 MAX	0.15 MAX	3.10- 3.80	0.15 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