

STRONG ENi5

CLASSIFICATION: AWS SFA 5.23 ENi5

SAW Wire for Cryogenic Steel applications



CHARACTERISTICS & APPLICATIONS

STRONG ENi5 is a Manganese - Nickle - Molybdenum alloyed, copper coated wire for the Submerged Arc Welding of micro alloyed steels where impact properties are required at negative temperatures along with corrosion resistance. The weld metal will provide good impact properties and corrosion resistance 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	1.20- 1.60	0.05- 0.30	0.020 MAX	0.020 MAX	0.15 MAX	0.75- 1.25	0.10- 0.30	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