Union S 2 Ni 3,5

SAW wire, low-alloyed, cryogenic

Classifications

EN ISO 14171-A	AWS A5.23 / SFA-5.23
S2Ni3	ENi3

Characteristics and typical fields of application

Union S 2 Ni 3,5 is a coppered solid wire for submerged arc welding of unalloyed and low alloyed fine grain steel grades and especially 3,5%Ni steel grades with matching wire composition for cryogenic application down to (at -80ºC / -105ºC).
The wire is alloyed with 3,3% Nickel to obtain great toughness in the weld metal.
It is suitable for cryogenic application such as pressure vessel and liquefied gas storage equipment manufacturing till a minimum temperature of -105 ºC (e.g. for CO_2 and Ethane) and arctic off-shore constructions.
This wire composition has been designed mainly for multi-pass welding procedures (not recommended for 2-run technology, neither for Tandem-process).

Recommended SAW flux:
UV 418 TT
UV 421 TT

Typical analysis

	C	Si	Mn	Ni	S	P
wt.-%	0.08	0.15	0.90	3.25	≤ 0.010	≤ 0.010

Operating data

Dimension mm
2.4
3.0
3.2
4.0

Approvals

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