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SIAT

**TECHNICAL SPECIFICATION
SUBMERGED ARC WELDING WIRE
PITTARC S4**

Document
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1. DESCRIPTION

Submerged arc welding wire conforming standards ISO 14171-A-S4 and AWS A5.17 EH14 suitable to join carbon steels for construction, pressure vessels, pipes, ship buildings.

2. PRODUCT CHEMICAL COMPOSITION (%)

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al
PITTARC S4	Min	0.10	1.75	-	-	-	-	-	-	-	-
	Max	0.15	2.20	0.10	0.025	0.025	0.15	0.15	0.15	0.30	0.03
AWS A5.17 EH14	Min	0.10	1.70	-	-	-	-	-	-	-	-
	Max	0.20	2.20	0.10	0.030	0.030	*	*	*	0.35	*
ISO 14171-A-S4	Min	0.07	1.75	-	-	-	-	-	-	-	-
	Max	0.15	2.25	0.15	0.025	0.025	0.15	0.15	0.15	0.30	0.03

Note: the standard AWS A5.17 require a total of residual elements lower than 0.50%.

3. WIRE DIMENSIONS

Standard diameter (mm) : 1.6 ; 2.0 ; 2.4 ; 3.2 ; 4.0 ; 4.8

Permissible deviations : ISO 544

4. STANDARD PACKAGING :

Wire basket rim LC (ISO 544 B450) of 27kg net weight. Each spool sealed in a polyethylene airtight bag and packed into a cardboard box. 42 spools stacked onto a pallet secured by thermoplastic shrink-wrapping (120 x 80 cm, 1134kg net weight). Available cardboard drums of about 320kg net weight, each one stacked onto a pallet 110x110cm of about 1280kg total weight (4 drums), secured by thermoplastic shrink-wrapping. On request packaging available from 15 kg up to 900 kg.

5. STANDARD IDENTIFICATION

A label is attached to the inside of each spool or drums and to every box or outside of the drums mentioning manufacturer, trade name, nominal diameter, spool type, net weight, heat number, standards and CE mark.

	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY
	PITTARC S4
0036 06 ref. DoP PITTARC S4-2014-04 EN 13479:2004 Use in metallic structures or in composite metal and concrete structures	Welding wire for carbon steels and fine-grained steels ISO 14171-A-S4 and AWS A5.17 EH14
	APPROVALS: TUV Nr.07172, DB-Zul.-Nr.52.044.03/01
	Weight kg Heat N° Diameter Spool type XX XXXXX/XX X,X mm X XXX

6. STANDARD CERTIFICATION

Documents according to EN 10204

7. APPROVALS: TÜV, DB.