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SIAT

**TECHNICAL SPECIFICATION
SUBMERGED ARC WELDING WIRE
PITTARC S2Si**

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1. DESCRIPTION

Submerged arc welding wire conforming standards ISO 14171-A- S2Si and AWS A5.17 EM12K suitable to join common steels for construction, pressure vessels, pipes.

2. PRODUCT CHEMICAL COMPOSITION (%)

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al
PITTARC S2Si	Min	0.07	0.80	0.15	-	-	-	-	-	-	-
	Max	0.15	1.20	0.35	0.025	0.025	0.15	0.15	0.15	0.30	0.03
AWS A5.17 EM12K	Min	0.05	0.80	0.10	-	-	-	-	-	-	-
	Max	0.15	1.25	0.35	0.030	0.030	*	*	*	0.35	*
ISO 14171-A- S2Si	Min	0.07	0.80	0.15	-	-	-	-	-	-	-
	Max	0.15	1.30	0.40	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 S2Si
0036 06 ref. DoP PITTARC S2Si-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-S2Si and AWS A5.17 EM12K
	APPROVALS: TÜV Nr.07172 DB-Zul.-Nr.52.044.04/01
	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.