



SAQ  
SIAT

**TECHNICAL SPECIFICATION  
SUBMERGED ARC WELDING WIRE  
PITTARC S2Si2**

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**1. DESCRIPTION**

Submerged arc welding wire conforming standards ISO 14171-A- S2Si2 and AWS A5.17 EM13K suitable to join common steels for construction, pressure vessels, pipes.

**2. PRODUCT CHEMICAL COMPOSITION (%)**

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al
<b>PITTARC S2Si2</b>	Min	0.07	0.90	0.40	-	-	-	-	-	-	-
	Max	0.15	1.30	0.60	0.015	0.015	0.10	0.10	0.10	0.20	0.01
<b>AWS A5.17 EM13K</b>	Min	0.06	0.90	0.35	-	-	-	-	-	-	-
	Max	0.16	1.40	0.75	0.025	0.025	*	*	*	0.35	*
<b>ISO 14171-A-S2Si2</b>	Min	0.07	0.80	0.40	-	-	-	-	-	-	-
	Max	0.15	1.30	0.60	0.025	0.025	0.15	0.15	0.15	0.30	-

\*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.

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<b>PITTARC S2Si2</b>			
Welding wire for carbon steels and fine-grained steels ISO 14171-A-S2Si2 and AWS A5.17 EM13K			
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:**

None.

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