

PITTARC S3Ni2½CrMo

SGQ
SIAT S.p.A.

1. DESCRIPTION

Submerged arc welding wire conforming standards EN ISO 26304-A S3Ni2,5CrMo and AWS A5.23 EG (similar to AWS A5.23 EM4) suitable to join Ni-Cr-Mo low alloy steels for construction, pressure, vessels, pipes.

2. PRODUCT CHEMICAL COMPOSITION (%)

		C %	Mn %	Si %	P %	S %	Cr %	Ni %	Mo %	Cu %	Al
Pittarc S3Ni2,5CrMo	min	0.07	1.30	0.10	-	-	0.50	2.20	0.40	-	-
	max	0.10	1.60	0.25	0.015	0.015	0.75	2.60	0.70	0.15	0.02
EN ISO 26304-A S3Ni2,5CrMo	min	0.07	1.20	0.10	-	-	0.30	2.00	0.40	-	-
	max	0.15	1.80	0.25	0.020	0.020	0.85	2.60	0.70	0.3	0.02

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, CE mark and approvals.

 PITTARC	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY
 0036 06 ref. DoP PITTARC S3Ni½CrMo-2019-03 EN 13479:2017 Use in metallic structures or in composite metal and concrete structures	PITTARC S3Ni2½CrMo
	Welding wire for carbon steels and fine-grained steels EN ISO 26304-A S3Ni2,5CrMo AWS A5.23 EG
APPROVALS: TÜV Nr.07172	
Weight kg	Heat N°
XX	XXXXX/XX
Diameter	Spool type
X,X mm	X XXX

6. STANDARD CERTIFICATION

Documents according to EN 10204.

7. APPROVALS

TÜV.

