

SW 701

Submerged Arc Welding Wire - Non Alloyed Steels

Standards

AWS/ASME SFA - 5.17	EL12
EN ISO 14171-A	S1
TS EN ISO 14171-A	S1

Approvals & Certificates

CE	TSE	TUV
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Properties and Applications

Solid, submerged arc welding wire suitable for welding general structural steels with a tensile strengths up to 510 N/mm², used in pressure vessel, pipe, shipbuilding and steel constructions. Copper coating increases electrical conductivity and resistance against rusting.

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn
Welding Wire	0.07	0.03	0.55

Typical Chemical Values of Weld Metal

Welding Flux	Type of Analysis	C	Si	Mn
SF 212	Weld Deposit	0.05	0.65	1.10
SF 113	Weld Deposit	0.04	0.45	1.45
SF 104	Weld Deposit	0.05	0.25	0.85
SF 304	Weld Deposit	0.05	0.25	0.90

Typical Mechanical Values of Weld Metal

Test Condition	Welding Flux	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)		
As welded	SF 104	410	480	30	0°C → 90	-20°C → 85	-30°C → 50
As welded	SF 304	420	490	30	0°C → 100	-20°C → 80	-30°C → 60
As welded	SF 212	460	530	28	20°C → 60	0°C → 30	
As welded	SF 113	400	500	30	0°C → 70	-20°C → 60	

Application Information

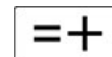
Welding Positions



Welding Parameters & Efficiency

Diameter (mm)
1.60
2.00
2.40
2.80
3.20
4.00
5.00

Polarity:



Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
41001G1GM2	1.60	200 kg	211.00	1	211.00	Fiber Drum
41001GJAM2	1.60	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

41001H2GM2	2.00	400 kg	415.60	1	415.60	Fiber Drum
41001HXAM2	2.00	25 kg	25.90	1	25.90	Wire Basket Spool (K435)
41001I2GM2	2.40	400 kg	415.60	1	415.60	Fiber Drum
41001IXAM2	2.40	25 kg	25.90	1	25.90	Wire Basket Spool (K435)
41001J2GM2	2.80	400 kg	415.60	1	415.60	Fiber Drum
41001JXAM2	2.80	25 kg	25.90	1	25.90	Wire Basket Spool (K435)
41001L2GM2	3.20	400 kg	415.60	1	415.60	Fiber Drum
41001L3GM2	3.20	600 kg	616.50	1	616.50	Fiber Drum
41001L8GM2	3.20	1000 kg	1030.00	1	1030.00	Spider
41001LXAM2	3.20	25 kg	25.90	1	25.90	Wire Basket Spool (K435)
41001M2GM2	4.00	400 kg	415.60	1	415.60	Fiber Drum
41001M3GM2	4.00	550 kg	616.50	1	616.50	Fiber Drum
41001M8GM2	4.00	1000 kg	1030.00	1	1030.00	Spider
41001MXAM2	4.00	25 kg	25.90	1	25.90	Wire Basket Spool (K435)
41001N2GM2	5.00	400 kg	415.60	1	415.60	Fiber Drum
41001N3GM2	5.00	550 kg	616.50	1	616.50	Fiber Drum
41001NXAM2	5.00	25 kg	25.90	1	25.90	Wire Basket Spool (K435)

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
 It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.