

# SW 803 1Ni1/4Mo

Submerged Arc Welding Wire - Unalloyed & Low Alloyed Steels

## Standards

AWS/ASME SFA - 5.23	EN5
AWS/ASME SFA - 5.23	F8A8-ENi5
AWS/ASME SFA - 5.23	F8P6-ENi5
EN ISO 14174 - A	S 50 6 FB S3Ni1Mo0.2
EN ISO 14171-A	S3Ni1Mo0.2
TS EN ISO 14174 - A	S 50 6 FB S3Ni1Mo0.2

## Properties and Applications

Nickel (Ni) and Molybdenum (Mo) alloyed solid submerged arc welding wire. Used in welding general structural steels and low alloy high tensile strength steels, used in pressure vessel, boiler, off-shore and heavy steel constructions. Copper coating increases electrical conductivity and resistance against rusting.

## Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Ni	Mo
Welding Wire	0.08	0.20	1.40	0.90	0.25

## Typical Chemical Values of Weld Metal

Welding Flux	Type of Analysis	C	Si	Mn	Ni	Mo
SF 401	Weld Deposit	0.06	0.30	1.45	0.70	0.20

## Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	520	610	24	-60°C → 50
Isil İşlem Sonrası (620°C 4 Saat)	530	620	28	-46°C → 70

## Application Information

### Welding Positions



### Welding Parameters & Efficiency

Diameter (mm)
4.00

## Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
42003MXAM2	4.00	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.