



SAQ  
SIAT

**TECHNICAL SPECIFICATION  
SUBMERGED ARC WELDING WIRE  
PITTARC S2Ni3**

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**1. DESCRIPTION**

Submerged arc welding wire conforming standards ISO 14171-A- S2Ni3 and AWS A5.23 ENi3 suitable to join Ni low alloy steels.

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

		C %	Mn %	Si %	P %	S %	Cr %	Ni %	Mo %	Cu %	Al %
<b>Pittarc S2Ni3</b>	min	0.07	0.90	0.05	-	-	-	3.15	-	-	-
	max	0.12	1.15	0.25	0.010	0.010	0.10	3.60	0.10	0.15	0.01
<b>EN 14171- A-S2Ni3</b>	min	0.07	0.80	0.05	-	-	-	2.80	-	-	-
	max	0.15	1.30	0.25	0.020	0.020	0.15	3.70	0.15	0.30	-
<b>AWS A5.23 ENi3</b>	min	-	0.60	0.05	-	-	-	3.10	-	-	-
	max	0.13	1.20	0.30	0.020	0.020	0.15	3.80	-	0.35	-

**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.

	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY		
<b>PITTARC S2Ni3</b>			
Welding wire for carbon steels and fine-grained steels ISO 14171 -A- S2Ni3 and AWS A5.23 ENi3			
<b>APPROVALS:</b>			
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

