



SAQ  
SIAT

**TECHNICAL SPECIFICATION  
SUBMERGED ARC WELDING WIRE  
PITTARC SH2**

Document  
Revision  
Date  
Page

SPP125  
09 i  
18.09.2014  
1/1

**1. DESCRIPTION**

Submerged arc welding wire according to ISO 14171-A-S2Ni1Cu and AWS A5.23 EG suitable to join atmospheric corrosion resistant steels for construction type COR-TEN.

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

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al
PITTARC SH2	min	0.08	0.90	0.15	-	-	0.15	0.65	-	0.40	-
	max	0.12	1.10	0.35	0.020	0.020	0.40	0.90	0.15	0.65	0.03
ISO 14171-A- S2Ni1Cu	min	0.08	0.70	0.15	-	-	-	0.65	-	0.40	-
	max	0.12	1.20	0.35	0.020	0.020	0.40	0.90	0.15	0.65	0.03

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 and CE mark.

    0036 06 ref. DoP PITTARC SH2-2014-04 EN 13479:2004 Use in metallic structures or in composite metal and concrete structures	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY								
	<b>PITTARC SH2</b>								
	Welding wire for carbon steels and fine-grained steels ISO 14171-A-S2Ni1Cu and AWS A5.23 EG								
	APPROVALS: TUV Nr.07172 DB-Zul.-Nr.52.044.10/01								
	<table border="1"> <tr> <td>Weight kg</td> <td>Heat N°</td> <td>Diameter</td> <td>Spool type</td> </tr> <tr> <td>XX</td> <td>XXXXXX</td> <td>X,X mm</td> <td>X XXX</td> </tr> </table>	Weight kg	Heat N°	Diameter	Spool type	XX	XXXXXX	X,X mm	X XXX
Weight kg	Heat N°	Diameter	Spool type						
XX	XXXXXX	X,X mm	X XXX						

**6. STANDARD CERTIFICATION**

Documents according to EN 10204

**7. APPROVALS:** TÜV, DB.