

# Solid Wire Electrode for Submerged Arc Welding

# BA-S3NiCrMo2,5

**Classification:** EN ISO 26304-A – S3Ni2,5CrMo  
SFA-5.23 / AWS A5.23 – EM4 mod.

**Typical analysis and chemical composition acc. to EN ISO 26304-A and AWS A5.23:** (Weight Percent)

Wire electrode	C	Si	Mn	Mo	Ni	Cr	P	S	Others
Typical analysis BA-S3NiCrMo2,5	0.10	0.17	1.50	0.55	2.40	0.50	0.008	0.007	Cu total 0.08
S3Ni2,5CrMo acc. to ISO 26304-A	0.07–0.15	0.10–0.25	1.20–1.80	0.40–0.70	2.00–2.60	0.30–0.85	0.020	0.020	Cu total 0.30
EM4 acc. to AWS A5.23	0.10	0.20–0.60	1.40–1.80	0.30–0.65	2.00–2.80	0.60	0.010	0.015	V 0.03 Ti/Zr/Al 0.10 Cu 0.25

## Characteristics:

NiCrMo-alloyed wire electrode with higher Mn-content for submerged arc welding of high tensile quenched and tempered fine grain steels in vessel and apparatus construction as well as high tensile pipe steels.

## Base Materials:

- Fine grain steels acc. to EN 10025, EN 10028: S620QL to S690QL  
Suitable flux: BF 10
- Pipe steels acc. to ISO 3183, EN 10208 and API-5: L625M/X90 to L690M/X100  
Suitable fluxes: BF 6.30 and BF 6.5
- Shipbuilding steels: high strength fine grain steels up to 690 MPa yield strength  
Suitable flux: BF 10

Flux type suitability is strongly dependent on its application. In combination with the wire electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

## Package forms:

Coils, spools, drums and spiders as standard package forms for SAW-wire electrodes, different package forms on request.

## Diameter:

2.0 – 5.0 mm; Sizes and tolerances acc. to ISO 544 and AWS A5.23.

## Wire electrode surface:

Copper-coated, smooth finish free from surface defects and foreign matter.