



SUBARC S2Mo

SUBARC S2Mo is a Copper-coated solid wire for submerged arc welding with 1.0% Mn and 0.5% Mo content to be used for the welding of creep-resistant low-alloy Mo steel keeping high yield values even after heat treatment. Generally used on boilers and pressure vessels.

CLASSIFICATIONS

AWS	A5.23-90	E A2
EN	12070	S Mo
EN	756	S2 Mo

TYPICAL CHEMICAL ANALYSIS (Wire)

% Carbon	0.109	% Sulphur	0.040
% Manganese	1.080	% Molybdenum	0.48
% Silicon	0.130	% Copper	0.123
% Phosphorous	0.010		

TYPICAL CHEMICAL ANALYSIS WELD METAL (SA 516 GR 70 PLATE)

Flux	HPF-N11X	Flux	HPF-N11X
% Carbon	0.060	% Sulphur	0.005
% Manganese	1.065	% Molybdenum	0.350
% Silicon	0.365	% Copper	0.087
% Phosphorus	0.017		

TYPICAL MECHANICAL PROPERTIES (ALL WELD METAL FROM ACTUAL TESTS)

Flux	HPF-N11X AS Welded	HPF-N11X PWHT 1HR @ 690°C
Flux/Wire Combination	F7A4-EA2	F6P4-EA2
Tensile Strength (MPa)	587	436
Yield Strength (MPa)	486	346
Elongation 4d %	31	33
Charpy Impact Value J	108J at -40°C	141J at -40°C

PACKING DATA & OPERATING PARAMETERS

Diameter (mm)	Current (DC+ / AC)		Item Number	Pack Mass (Kg)
	Amps	Volts		
2.40	350	28	078-122	27
3.20	450	28	078-124	27
4.00	500	30	078-126	27

For more detail on the fluxes used, please refer to the relevant flux data sheet.

The information contained or otherwise referenced herein is presented only as typical without guarantee or warranty, and Afrox expressly disclaims any liability incurred from any reliance thereon. No data is to be construed as recommended for any welding condition or technique not controlled by Afrox.

For more information contact the Afrox Customer Service Centre, tel: 0860 020202 or e-mail: customer.service@afrox.boc.com Website: www.afrox.com

