

Classifications

EN ISO 14171-A	AWS A5.23 / SFA-5.23
TZ3Ni1Mo	ECNi5

Characteristics and typical fields of application

diamondspark S 550 HP is a coppered seamless flux cored wire for submerged arc welding of pipe steels API-5L X70 and fine-grained structural steels up to MSYS = 550 MPa. The wire is a coppered seamless flux cored wire with a good resistance to deformation (wire feed rollers) and is very easy to straighten to ensure the best current transfer with a low contact tip consumption. The wire is not sensitive to moisture pick up. It can be combined with several fluxes and has been designed for circumferential pipe welding procedures that target minimum arc time with lowest defect ratio. The wire provides an increased deposition rate compared to solid SAW-wire.

Typical fluxes to combine

Process	Name	EN ISO 14174
SAW	UV 400	S A AB 1 67 AC H5
SAW	UV 419 TT-W	S A FB 1 55 AC H5
SAW	UV 420 TTR-C	S A FB 1 65 DC H4
SAW	UV 422 TT-LH	S A FB 1 65 AC H5

