

Classifications

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|----------------|--------------------|
| EN ISO 14343-A | AWS A5.9 / SFA-5.9 |
| S 16 5 1 | - |

Characteristics and typical fields of application

Solid SAW wire of S 16 5 1 type for submerged arc welding, designed for welding Outokumpu 248 SV / 420 and steel castings with corresponding composition. Applications include propellers, pumps, valves and shafts. This alloy has high safety against cracking, superior to many other martensitic consumables. The resistance to general and pitting corrosion is similar to that of 1.4301 / 304.

Typical analysis of the solid wire

| | C | Si | Mn | Cr | Ni | Mo |
|-------|------|------|-----|------|-----|-----|
| wt.-% | 0.02 | 0.35 | 1.3 | 16.0 | 5.5 | 1.0 |

Typical fluxes to combine

| Process | Name | EN ISO 14174 |
|---------|--------------------------------|--------------|
| SAW | Marathon 203 (BÖHLER BB 203) | |
| SAW | Marathon 805 (Avesta Flux 805) | S A AF 2 DC |

