



UP S2

Désignation normalisée

AWS A5.17 : EM12
AWS A5.23 : EM12

ISO 14171-A : S2

Propriétés et Applications

Fil plein cuivré pour le soudage à l'arc submergé (sous flux) des aciers non allié (C-Mn).

Principales applications : Construction automobile, ferroviaire, navale. Construction et maintenance d'équipements de travaux publics. Mines, Carrières, matériel agricole...

Nuances soudables:

Aciers de construction à usage général:

EN	ASTM
S275 – S355	A106 grade A, B, C
P275 – P355	A131 grade A, B, D
L210 – L360	A139
	A210 grade A1, C

Analyse Chimique type (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Al	P	S	Fe
Min	0.08		0.80								
Max	0.15	0.10	1.25	0.15	0.15	0.15	0.30	0.030	0.025	0.025	Base
Type	0.10	0.08	1.1	0.04	0.05	0.01	0.07	0.001	0.010	0.008	Base

Paramètres et Conditions d'emploi

	Ø (mm)	Paramètres de Soudage				Flux
		Intensité (A)	Tension (V)	Stick out (mm)	Vitesse (cm/min)	
SAW AC / = +	2.4	360 - 450	25 - 30	18	40 - 60	UP LA01
	3.2	400 - 500	28 - 32	20	40 - 60	UP LA04
	4.0	500 - 600	30 - 35	22	50 - 60	UP LA05 UP BF10

Température entre passe : <200°C.

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www.fsh-welding.com - info@fsh-welding.fr