



# NOUVARC S3 + ASK 74F

## Submerged Arc Welding Wires & Fluxes

**AWS/SFA A 5.17**

**F7A4 +EH14**

### Characteristics

High quality flux in combination with our EH14 filler wire useful for welding mild steel and low alloy steel to get excellent radiographic quality welds with superior mechanical and sub zero impact properties and with crack resistance. Extremely smooth and shiny weld bead. Easily detachable slag.

### Drying Requirements

Re baking is recommended at 300°C for one hour

### Applications

Structural, Pressure Vessels and Boilers involving steels such as e EN 10025 S355 J2 G3, IS 2002 Gr 2B, A515 Gr 70, a516 Gr 70 and B.API -2H steels, etc., Shiplifts, Machine building, automobiles etc., involving medium tensile, carbon and low alloy steels.

### Typical End Chemistry of Weld Metal

C%	Mn%	Si%	S%	P%
0.08	1.80	0.25	0.25 max	0.030 max

### Mechanical Properties of Our Weld Metal

UTS (Mpa)	YS (Mpa)	ELONG %	CVN - 40°C
550 min	480 min	25 min	42J min

[Values obtained with good operating conditions]

### Applicability

Current : 1000 Amps Max  
Voltage : 27 - 32 V  
Polarity : AC/DC +

### Packing Particulars

Diameter of Wire : 2.0 mm / 2.5 mm / 3.15 mm /  
4.0mm / 5.0 mm  
Our packing norms 25 Kg wire  
250 Kg & 500 Kg Drums  
25 Kg Flux/Bag (Atm shield)  
100 Kg Drum

ISO 9001 Certified Company

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