



Low Alloy Steel SAW Wire



Please Note: Chemistry listed below for wire/strip are typical values only.

Spoolarc 40B EA2

Spoolarc 40B is designed for single or multipass welding of carbon and low alloy steels. Produces good as welded and stress relieved impact toughness. Weld metal tensile strength is in excess of 70 ksi (483 MPa). Applications include pressure vessel fabrication and other similar welds, which require postweld heat treatment.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.10	1.15	0.03	0.017	0.015	-	-	0.50	-

Spoolarc 40 EA3

Spoolarc 40 is designed for single or multipass wire for welding carbon and low alloy steels. Produces good as welded and stress relieved impact toughness. Weld metal tensile strength is in excess of 80 ksi (552 MPa). Applications include pressure vessel fabrication and other similar welds, which require postweld heat treatment.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.15	2	0.03	0.017	0.015	-	-	0.50	-

Spoolarc U515 EB2

Spoolarc U515 is designed for use on low alloy steels up to 1.25% Cr - 0.5% Mo. Applications include process piping, heat exchangers and pressure vessel fabrication.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.10	0.65	0.18	0.010	0.010	1.5	-	0.50	-

Autrod 13.20SC EB3R

ESAB's **OK Autrod 13.20SC** is a copper-coated low alloy submerged arc wire designed for the welding of creep-resistant steel of the 2 1-4% Cr-1% Mo type. When combined with OK Flux 10.63, OK Autrod 13.20SC produces a metallurgically clean weld, which is capable of meeting X-factor of less than 15 and J-factor of less than 120. This combination fulfills the stringent requirements for toughness after step cooling treatment of the weld metal. OK Autrod 13.20SC can also be combined with OK Flux 10.62 for applications not requiring step cooling treatment. OK Autrod 13.20SC is used for welding process piping, heat exchangers and pressure vessel fabrication.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.10	0.55	0.15	0.005	0.006	2.25	-	0.95	-

Spoolarc 44 EF2

Spoolarc 44 is designed for single or multipass welding where high strength and impact toughness are required. Weld metal tensile strengths of 80 ksi (552 MPa) are maintainable after long-term stress relieving (50 hrs or more). The presence of Ni in the wire chemistry helps increase low temperature impact toughness. Applications include pressure vessels, structural supports and some heat treatable valves and fittings.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.13	2.05	0.05	0.010	0.010	-	0.65	0.50	-



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Spoolarc 100 EF5

Spoolarc 100 is designed for low alloy quenched and tempered steels. Weld metal mechanical properties include high yield strength materials (exceeds 100 ksi/690 MPa) and low temperature impact toughness. Applications include heat treatable valves and fittings, structural weldments and low temperature pipe valves.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.12	1.91	0.07	0.007	0.006	0.38	2.40	0.50	Cu 0.32

Spoolarc 95 EM2

Spoolarc 95 is military-grade, high-strength wire used to weld HY-80 steels. Applications for Spoolarc 95 include military tanks, ships and submarines.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.007	1.40	0.35	0.008	0.007	0.20	1.80	0.35	-

Spoolarc 120 EM4

Spoolarc 120 is designed for welding high strength quenched and tempered steels. Weld metal mechanical properties produce high tensile strengths, in excess of 120 ksi (825 MPa). Applications for Spoolarc 120 include military tanks, ships, submarines and other similar fabrication.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.07	1.3	0.35	0.007	0.008	0.4	2.6	0.45	-

Spoolarc 75 ENi1K

Spoolarc 75 is a copper-coated 1% nickel solid wire for carbon steel and low alloy welding applications using either the MIG/Gas Metal Arc Welding (GMAW) or Submerged Arc Welding (SAW) processes. Spoolarc 75 produces a deposit that meets the requirements of AWS D1.1 and D1.5 and is designed to weld weathering steels and/or where improved low temperature impact toughness is specified. Shielding gas choices for Spoolarc 75 are Ar/CO₂ mixtures containing a minimum of 75% Ar or the 98% Ar/2% O₂. In the SAW mode, Spoolarc 75 is typically used with a neutral flux such as ESAB OK Flux 429, 10.71, and 10.62. Spoolarc 75 is used for bridge and structural welding.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.07	1.13	0.49	0.005	0.005	-	0.90	-	-

Spoolarc ENi-4 ENi4

Spoolarc ENi-4 is designed for single or multipass welding on high steels. Produces good low temperature toughness on a variety of base materials. Weld metal tensile strengths are in excess of 90 ksi (620 MPa) in both the as welded and stress relieved conditions. Applications include pressure vessels, offshore oil rigs, bridges and other structural steel fabrication.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.17	0.73	0.19	0.003	0.004	-	1.74	0.17	-