

SDX S2Ni1-ENi1

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Type no: 821

Characteristics

- Low alloyed copper coated solid wire electrode for submerged arc welding
- Nickel alloyed for improved low temperature impact toughness
- Recommended flux: Hobart SWX 150
- Storage: Product should be stored in a dry, enclosed environment and in its original intact packaging

Classification

EN ISO / AWS

EN ISO 14171: S2Ni1

AWS A5.23: ENi1

Chemical Composition - Typical Values

%C	%Si	%Mn	%P	%S	%Cr	%Ni	%Mo	%Cu	%Al
0.09	0.12	0.96	0.009	0.007	0.04	0.97	0.02	0.05	0.01

Recommended Fluxes - Standard Packaging and Item numbers

Package	SWX 150
22.7 kg (50 lbs) Al Bag EAE	150022300H
950 kg (2090 lbs) Double Bag	150079F00H

Standard Diameters, Packages and Item numbers - North America

Package	2.4 mm (3/32")	3.2 mm (1/8")	4.0 mm (5/32")
25 kg (55 lbs) Wire basket K-415	821241025H	821321025H	821401025H

Customers Located in North America:

Refer to the table above for standard part numbers exclusive to North America.

 For a complete list of diameters and packaging, please contact Hobart Brothers at +1 (800) 424-1543 for US customer service or e-mail subarc@itw-welding.com

Standard Diameters, Packages and Item numbers - Outside North America

Package	2.4 mm (3/32")	3.2 mm (1/8")	4.0 mm (5/32")
25 kg (55 lbs) Wire basket K-415	8212410250	8213210250	8214010250

Customers Located Outside North America:

 Refer to the table above for standard part numbers exclusive to locations outside North America. For a complete list of diameters and packaging, please contact the ITW Welding sales office at +46 (0) 31 787 5000 or e-mail subarc@itw-welding.com

Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products please visit www.hobartbrothers.com/where-to-buy to find your closest Hobart representative or send an e-mail to subarc@itw-welding.com for further assistance.

DISCLAIMER:

The information contained or otherwise referenced herein is for reference purposes only and is presented only as "typical." Typical data are those obtained when welding and testing are performed in accordance with applicable AWS and/or EN ISO specification(s). Other tests and procedures may produce difference results and typical data should not be assumed to yield similar results in a particular application or weldment. No data is to be construed as a recommendation for any welding condition or technique not controlled by ITW Welding. ITW Welding does not assume responsibility for any results obtained by persons over whose methods it has no control. It is the user's responsibility to determine the suitability of any products or methods mentioned herein for a particular purpose. In light of the foregoing, ITW Welding specifically disclaims any liability incurred from reliance on such information, and disclaims all guarantees and warranties, express or implied, including warranties of merchantability and fitness for a particular purpose, and further disclaims any liability for consequential or incidental damages of any kind, including lost profits.

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 St, # 130, Miami, FL 33166-6672 (can also be downloaded online at www.aws.org); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.

Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers Company is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

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Specification: PDS821 // **Type Number:** 821 // **Revision:** 1 // **Replaces:** 0 // **Approved By:** L.Andersson, P.Jeirud

Prepared By: I.Oziewicz // **Reason For Issue:** Format Standardization.