

Spoolarc 75 (SAW)

Spoolarc 75 is a copper-coated 1% nickel solid wire for carbon steel and low alloy welding applications using Submerged Arc Welding (SAW) processes. Spoolarc 75 produces a deposit that meets the weathering 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. 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.

Specifications	
Classifications	ASME SFA 5.23 : ENi1K AWS A5.23 : ENi1K
Industry	Mobile Equipment Ship/Barge Building Industrial and General Fabrication Bridge Construction

Alloy Type	Low alloy - Nickel 0.8 - 1.10%
------------	--------------------------------

Typical Wire Composition %								
C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.08	0.89	0.46	0.01	0.00	0.98	0.04	0.01	0.07

Typical Weld Metal Analysis %								
C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.08	0.89	0.46	0.01	0.00	0.98	0.04	0.01	0.07