Select Ni2S

Low Alloy / Flux Shielded / Submerged Arc

PRODUCT DATA SHEET

FEATURES

- Contains 2.00-2.90% nickel to produce a ductile deposit with good low temperature toughness.
- Select Ni2S is ideal for applications involving the welding of carbon and certain low alloy steels, in applications where low temperature toughness is required.
- Higher deposition rates than solid wire when run at the same current level
- Exhibits a broader and shallower bead profile than when using solid wire, reducing the tendency for burn through
- Capable of running directly over root passes with proper procedure - eliminating requirement for a hot pass
- Easy slag removal - reduces post weld clean up time
- Arcflux BF-10MW helps to maximize the impact properties and is the recommended flux. Other basic fluxes can be used as well.

CONFORMANCES

AWS A5.23	ECNi2
	F8A8-ECNi2-Ni2
	F8P8-ECNi2-Ni2
ASME SFA 5.23	ECNi2
	F8A8-ECNi2-Ni2
	F8P8-ECNi2-Ni2

DIAMETERS (in [mm])

1/8 (3.2), 5/32 (4.0)

POSITIONS

FLUX

Arcflux BF-10MW

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

Flux	C	Cu	Mn	Ni	P	S	Si
ARCFLUX BF-10 MW	0.06	0.07	1.32	2.08	0.017	0.010	0.26

TYPICAL MECHANICAL PROPERTIES

Flux	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp	CVN @ -60°F (-50°C) ft-lb (J)	CVN @ -80°F (-60°C) ft-lb (J)
ARCFLUX BF-10 MW	91 (628)	78 (538)	28	As-Welded	-	64 (87)	36 (49)
ARCFLUX BF-10 MW	85 (586)	70 (483)	29	PWHT	1150°F for 1 hr	85 (115)	72 (98)

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RECOMMENDED WELDING PARAMETERS

Diameter in (mm)	Flux	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
1/8 (3.2 mm)	ARCFLUX BF-10 MW	Flat & Horizontal	55 (1.4)	350	28.5	1 - 1 1/4 (25 - 32)
		Flat & Horizontal	75 (1.9)	450	29.5	1 - 1 1/4 (25 - 32)
		Flat & Horizontal	100 (2.5)	550	30.5	1 - 1 1/4 (25 - 32)
5/32 (4.0 mm)	ARCFLUX BF-10 MW	Flat & Horizontal	50 (1.3)	450	30	1 - 1 1/4 (25 - 32)
		Flat & Horizontal	65 (1.7)	550	31	1 - 1 1/4 (25 - 32)
		Flat & Horizontal	80 (2.0)	650	32	1 - 1 1/4 (25 - 32)

** WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance*

PACKAGING (lbs (kgs))

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

**Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.*

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.

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