

## Classifications

**EN ISO 14171-A**
**AWS A5.23 / SFA-5.23**

S 46 4 AB S2Mo H5

F8A4-EA2-A2 / F8P4-EA2-A2

## Characteristics and typical fields of application

**Union S 2 Mo - UV 400** is a wire-flux combination for submerged-arc welding of unalloyed and low-alloyed steel grades. The combination is used in joining and surfacing applications with general-purpose structural steels, fine grained structural steels, boiler and pipe steels. It can be used on DC and AC. This combination combines very good welding characteristics with a high level of strength and toughness in the weld metal. It is suitable for single and multi-pass butt and fillet welding and also 2-run technique. Very good slag detachability.

**UV 400** is an agglomerated flux of aluminate basic type. For information regarding this welding flux see our detailed data sheet.

## Base materials

General and fine grained structural steels, shipbuilding steels, pipe steels up to 460 MPa minimum yield strength.

## Typical analysis

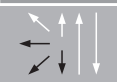
wt.-%	C	Si	Mn	Mo
wire	0.10	0.15	1.05	0.55
all-weld metal	0.06	0.35	1.35	0.50

## Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_e$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact energy ISO-V KV J		
	MPa	MPa	%	-40°C	-20°C	20°C
u, DC+	≥ 470	≥ 550	≥ 22	≥ 47	≥ 60	≥ 100
a1, DC+	≥ 470	≥ 550	≥ 22	≥ 47	≥ 60	≥ 100

u untreated, as welded; a1 = 1 hour 620 °C

## Operating data

	Polarity	DC / AC	Dimension mm	
				2.0
				2.5
				3.0
				4.0
				4.8

## Approvals

TÜV (06233), DB (51.132.03), ABS, BV, DNV GL, LRS, CE