

# NS Plus<sup>®</sup> and NS CopperFree<sup>™</sup> CARBON WELDING WIRES

**TYPICAL WIRE CHEMISTRY PERCENTAGES (as required per AWS)**

		C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
<b>101</b>	NS Plus <sup>®</sup> -101 Typ.	0.09	1.17	0.59	0.009	0.009	0.16	0.04	0.04	0.012	0.005
	NS 101 CopperFree <sup>™</sup> Typ.	0.09	1.17	0.60	0.012	0.014	0.07	0.06	0.07	0.008	0.005
	<b>AWS A5.18/A5.18M</b>	<b>0.06/0.15</b>	<b>0.90/1.40</b>	<b>0.45/0.70</b>	<b>0.025 (max.)</b>	<b>0.035 (max.)</b>	<b>0.50 (max.)</b>	<b>0.15 (max.)</b>	<b>0.15 (max.)</b>	<b>0.15 (max.)</b>	<b>0.03 (max.)</b>
	<b>AWS A5.17/A5.17M</b>	<b>0.06/0.16</b>	<b>0.90/1.40</b>	<b>0.35/0.75</b>	<b>0.030 (max.)</b>	<b>0.030 (max.)</b>	<b>0.35 (max.)</b>	-	-	-	-
<b>102</b>	NS Plus <sup>®</sup> -102 Typ.	0.09	1.76	0.66	0.009	0.01	0.14	0.07		0.46	
	NS 102 CopperFree <sup>™</sup> Typ.	0.1	1.81	0.63	0.016	0.016	0.06	0.06		0.47	
	<b>AWS A5.28/A5.28M</b>	<b>0.07/0.12</b>	<b>1.60/2.10</b>	<b>0.50/0.80</b>	<b>0.025 (max.)</b>	<b>0.025 (max.)</b>	<b>0.50 (max.)</b>	<b>0.15 (max.)</b>		<b>0.40/0.60</b>	
	<b>AWS A5.23/A5.23M</b>	<b>0.05/0.15</b>	<b>1.60/2.10</b>	<b>0.50/0.80</b>	<b>0.025 (max.)</b>	<b>0.025 (max.)</b>	<b>0.35 (max.)</b>			<b>0.40/0.60</b>	
<b>115</b>	NS Plus <sup>®</sup> -115 Typ.	0.08	1.49	0.9	0.011	0.01	0.14	0.05	0.04	0.008	0.006
	NS 115 CopperFree <sup>™</sup> Typ.	0.09	1.52	0.91	0.012	0.011	0.07	0.06	0.06	0.01	0.01
	<b>AWS A5.18/A5.18M</b>	<b>0.06/0.15</b>	<b>1.40/1.85</b>	<b>0.80/1.15</b>	<b>0.025 (max.)</b>	<b>0.035 (max.)</b>	<b>0.50 (max.)</b>	<b>0.15 (max.)</b>	<b>0.15 (max.)</b>	<b>0.15 (max.)</b>	<b>0.03 (max.)</b>
	<b>AWS A5.17/A5.17M</b>	<b>0.06/0.15</b>	<b>1.40/1.85</b>	<b>0.80/1.15</b>	<b>0.030 (max.)</b>	<b>0.030 (max.)</b>	<b>0.35 (max.)</b>				