

NS Plus[®] and NS CopperFree[™] CARBON WELDING WIRES

TYPICAL WIRE CHEMISTRY PERCENTAGES (as required per AWS)

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