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Perfect Welding Worldwide

20 YEARS 1991-2011 NST

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Nittetsu Seamless Wire



- No pick up of moisture = easy storing and handling
- Copper coated surface, exact roundness = excellent conductivity and troublefree wirefeeding
- Deep penetration in base material ensures good fusion
- Excellent also for use in automated welding as seamless wire does not oscillate
- Reduced consumption of contact tips
- Stable and spatterfree arc



Flux — Steel — Copper coating

News

- New Nittetsu Seamless Wire (NWS) joins with NST AS
- New NST subsidiary office in Singapore: NST Welding Asia Pte Ltd.
- NST Celebrates 20 Years!
- New! NST Electrodes

Login staff

Nittetsu Seamless Wire (NWS)

MIG / MAG

NST Electrodes

The NST program for TIG welding

Ceramic backing

NST IRIG Pickling products

NST Group carbon arc electrodes

Wire feeding systems

DMT Welding Machines

The NST program to maintain and repair welding

Inspection Certificate

According to EN 10204, type 3.1

Certified Material Test Report

Test Report No. 1413142V

Date of issue: November 4, 2014

Hikari Plant

Nippon Steel & Sumikin Welding Co., Ltd.

Purchaser: Norek Sveiseteknikk AS

Purchaser's Spec. No.: NSTV-4 Rev.0

1. Materials

Trade Designation	AWS	EN	Size	Manufacturing No	Manufacturing Date
NSSW SF-1A	A5.20 E71T-1M	EN ISO 17632-A : T 42 2 Z P M 1 H5	1.2 mm	4S102FP960	Aug. 4, 2014

2. Welding Conditions

Base Metal (mm)	SM490A	Welding Position	Flat	Hydrogen Content of Deposited Metal
20x25x300				
Current DC(A)	270	Kind of Gas	89%Ar+9%CO ₂	Acc. to ISO 3690
Voltage(V)	27	Flow Rate of Gas (l/min)	25	HDM(ml/100g)
Travel Speed (mm/min)	25	Preheat/Inter-pass Temp. (°C)	RT/220/ 149	Ave.
Wire extension (mm)	25		2.9, 3.2, 2.9	3.0

3. Test results of All-Weld-Metal

Tension Test	Conditions	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation(%)
	AW	527	598	26.6

Impact Test (J)	Conditions	Temp. (°C)	Ind. Value	Ave.
	AW	-20	106, 103, 109	106

Chemical composition (%)

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	Ti	B	Al	As	V	Sb	Pb	Nb
0.05	0.09	1.34	0.013	0.003	0.23	*	*	*	*	*	*	*	*	*	*	*

*Below specified maximum

Other elements of the Data Sheet : Below specified maximum
S, P and N of the strip : Below specified maximum

Statement :
We hereby certify that the contents of this report are correct and accurate, and all operations performed by us or our subcontractors are in compliance with the requirements of the DATA SHEET No. NSTV-4 Rev.0

No.140843HAT(MIT.6831)

Net Weight
4S102FP960 : 19,500 kg

Certified by TADAMI ASHIDATE
Group Manager, Quality Control Dept.

This is electronically made and is not signed.

Wszystkie atesty dostępne on-line na naszej stronie www.nst.no