

## AUTOTHERME C-Mo

**CODIFICATION:**                      **AWS :**    SFA 5.28 ER70S-A1

### CHARACTERISTICS AND APPLICATIONS:

Autotherme C-Mo is a copper-coated solid wire for GMAW, available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. It is ideally suited for welding of low alloy ferritic steels of similar composition. The weld metal possesses good high temperature properties. Typical applications include the welding of Carbon Molybdenum steels such as, ASTM Grade F1 of SA-182 & SA-336, Grade A of SA-204, Grade T1/T1a/T1b of SA-209, Grade WC1 of SA-217, Grade A of SA-302, Grade P1 of SA-335, Class 1 of A grades of SA-533, etc.

### TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Mo	Cu
%	0.065	1.20	0.45	0.010	0.012	0.55	0.10

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

**(PWHT: 620°C FOR 1 HR)**

UTS (MPa)	YS (MPa)	Elongation (L=4d) %
560	450	25.0

### WELDING PARAMETER : DC(+)

Diameter	Flat	
	Volt, V	Current, A
1.20 mm	27-32	300-360
1.60 mm	25-30	340-420

**SHIELDING GAS:** Argon/ 1-5% O<sub>2</sub>

**WELDING POSITION:** H, F, VU, OH

**APPROVAL:** CIB-MP

### PACKING:

STANDARD SIZE	1.2 mm & 1.6 mm.
QUANTITY	15.0 kgs wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.