
	Autotherme Grade-A	
	Copper coated solid wire for Submerged Arc Welding	

CLASSIFICATION: AWS: SFA 5.17
EL-8

CHARACTERISTICS & APPLICATIONS:

Copper coated Low-Manganese general purpose solid wire capable of making single pass or multiple pass welding for structural steel Overlaying and hard facing with suitable flux. Autotherme Grade-A wire is ideally suited for welding of structural steels, offshore platform, Ships, Pressure vessel and suitable for overlaying and build up of idlers and rollers etc.

CHEMICAL COMPOSITION OF SOLID WIRE, WT. %:

Element	C	Mn	Si	S	P	Cu
Range	0.10 Max	0.25-0.60	0.07 Max	0.030 Max	0.030 Max	0.35 Max
Typical	0.07	0.40	0.03	0.020	0.020	0.20

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, WT. %:

MAXFLUX	Element	C	Mn	Si	S	P	Cu
SAF-2	Typical	0.05	1.10	0.35	0.027	0.028	0.15

MECHANICAL PROPERTIES OF WELD METAL:

MAXFLUX	Property	0.2%YS (MPa)	UTS (MPa)	EI(L=4d) (%)	CVN Impact (J) at	
					RT	0°C
SAF-2	Typical	410	500	26	55	30

PACKING:	STANDARD SIZE	Diameter 2.5mm, 3.2mm & 4.0 mm
	QUANTITY	<ul style="list-style-type: none"> ➤ 25 kg. Wire in metallic ring. ➤ Identification-Brand name & size is printed on label. ➤ Packed in corrugated cardboard box. ➤ 100Kg, 250kg, 500Kg & 750kg Drum Packing also available on request.

An ISO 9001: 2008 COMPANY
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