
 ESTD. 1966 D&H sécheron Complete Welding Support	<h2>Autotherme Grade -B (Mod)</h2>	
	Copper coated solid wire for Submerged Arc Welding	

CLASSIFICATION: AWS: SFA 5.17
EM-13K

CHARACTERISTICS & APPLICATION :

Copper coated Medium- Manganese, Silicon killed wire to be used with neutral or semi basic flux for welding of general purpose fabrication, off-shore platform, medium and high tensile structural steels, ships, boiler and pressure vessels application etc.

CHEMICAL COMPOSITION OF SOLID WIRE, WT. %:

Element	C	Mn	Si	S	P	Cu
Range	0.06 - 0.16	0.90-1.40	0.35-0.75	0.030 Max	0.030 Max	0.35 Max
Typical	0.09	1.08	0.56	0.027	0.026	0.20

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, WT. %:

MAXFLUX	Element	C	Mn	Si	S	P	Cu
SAF-2	Typical	0.07	1.25	0.50	0.028	0.026	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	-20°C
SAF-2	Typical	418	515	25	60	40	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 Packingalso available on request.

<p>An ISO 9001: 2008 COMPANY</p> <p>D&H Sécheron Electrodes Private Limited</p> <p>44-46, Industrial Estate, Kila Maidan, Indore-452 006, India, Ph: 0731 2412331-2, 4229222 Fax: 0731 4229260 E-mail: tsdr@dnhsecheron.net Website: www.dnhsecheron.com</p>	JUN 2017 (Rev.: 01)
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