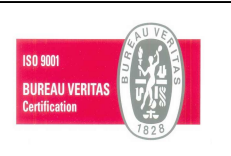




Autotherme Grade-B

Copper coated solid wire for Submerged Arc Welding



CLASSIFICATION: AWS: SFA 5.17
EM-12K

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	0.05-0.15	0.80-1.25	0.10-0.35	0.030 Max	0.030 Max	0.35 Max
Typical	0.09	0.90	0.20	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	510	25	60	40	30

PACKING:	STANDARD SIZE	Diameter 2.5mm, 3.2mm & 4.0 mm
		QUANTITY

An ISO 9001: 2008 COMPANY

D&H Sécheron Electrodes Private Limited

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