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| <br><b>D&amp;H</b><br>sécheron<br>Complete Welding Support | <h2>Autotherme Grade-C</h2>                        | <br>ISO 9001<br>BUREAU VERITAS<br>Certification |
|   | Copper coated solid wire for Submerged Arc Welding |  |

**CLASSIFICATION:** AWS: SFA 5.17

EH-14

**CHARACTERISTICS & APPLICATIONS:**

Copper coated high medium-manganese, wire to be used in combination with basic type of flux for the welding of structural steel pressure vessel and boilers involving steels such as A-515 Gr.70.A - 516 Gr.70, IS-8500 etc.

**CHEMICAL COMPOSITION OF SOLID WIRE, WT. %:**

| Element | C         | Mn        | Si       | S         | P         | Cu       |
|---------|-----------|-----------|----------|-----------|-----------|----------|
| Range   | 0.10-0.20 | 1.70-2.20 | 0.10 Max | 0.030 Max | 0.030 Max | 0.35 Max |
| Typical | 0.12      | 1.80      | 0.05     | 0.027     | 0.028     | 0.20     |

**CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, WT. %:**

| MAXFLUX      | Element | C    | Mn   | Si   | S     | P     | Cu   |
|--------------|---------|------|------|------|-------|-------|------|
| <b>SAF-4</b> | Typical | 0.13 | 1.80 | 0.38 | 0.028 | 0.027 | 0.15 |

**MECHANICAL PROPERTIES OF WELD METAL:**

| MAXFLUX      | Property | 0.2%YS (MPa) | UTS (MPa) | EI (L=4d) (%) | CVN Impact (J) at |       |       |
|--------------|----------|--------------|-----------|---------------|-------------------|-------|-------|
|              |          |              |           |               | -18°C             | -29°C | -40°C |
| <b>SAF-4</b> | Typical  | 418          | 530       | 26            | 90                | 75    | 45    |

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

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| <b>An ISO 9001: 2008 COMPANY</b>  |  |
| <b>D&amp;H Sécheron Electrodes Private Limited</b>  |  |
| 44-46, Industrial Estate, Kila Maidan, Indore-452 006, India, Ph: 0731 2412331-2, 4229222 Fax: 0731 4229260<br>E-mail: tsd@dnhsecheron.net Website: www.dnhsecheron.com |  |
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