



Autotherme Grade-E (CTOD)

Copper coated solid wire for Submerged Arc Welding



CLASSIFICATION: AWS: SFA 5.17
EH-10K

CHARACTERISTICS & APPLICATIONS :

Copper coated High manganese special wire to be used in combination with acidic as well as basic flux for the welding of structural steels and fine grained steels requiring, 480 MPa tensile strength in the stress relieved conditions.

CHEMICAL COMPOSITION OF SOLID WIRE, WT. %:

Element	C	Mn	Si	S	P	Cu
Range	0.07-0.15	1.30-1.70	0.05-0.25	0.025 Max	0.025 Max	0.35 Max
Typical	0.10	1.55	0.21	0.010	0.013	0.20

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, WT. %:

MAXFLUX	Element	C	Mn	Si	S	P	Cu
SAF-8 (LS) CTOD	Typical	0.08	1.55	0.21	0.010	0.013	0.15

MECHANICAL PROPERTIES OF WELD METAL:

MAXFLUX	Property	0.2%YS (MPa)	UTS (MPa)	EI (L=4d) (%)	CVN Impact (J) at		
					-29°C	-40°C	-46°C
SAF-8 (LS) CTOD	Typical	520	568	24	140	124	110

CTOD TEST: Satisfactory as per BS 7448-1991 Part 2

Average CTOD =1.41 mm

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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