



# Autotherme Grade-E (Mod)

Copper coated solid wire for Submerged Arc Welding



**CODIFICATION:** **AWS: SFA 5.17**  
**EH11K**

**CHARACTERISTICS:** Autotherme Grade-E (Mod) Copper Coated with high manganese contents solid wire for submerged arc welding. These are suitable for welding of structural steels & fine grain steels.

**APPLICATIONS:** Autotherme Grade-E (Mod) solid wire is suitable for welding of low alloys structural steels. The weld metal possesses high tensile strength and meets the radiographic quality requirements. Especially suitable for welding of structural steels, pressure vessels and other fabrication steels. Suitable for welding of ASTM steels: Grade ASTM A285Gr.A, B, C & ASTM A516, 515Gr.70 etc.

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

Element	C	Mn	Si	S	P	Cu
Range	0.07-0.15	1.40-1.85	0.80-1.15	0.030 Max	0.030 Max	0.35 Max

**CHEMICAL COMPOSITION OF UNDILUTED WELD METAL WITH MAXFLUX SAF – 8 (LS) WT. %:**

Element	C	Mn	Si	S	P	Cu
Typical	0.08	1.65	0.86	0.010	0.014	0.17

**TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL**

Maxflux	Property	UTS (MPa)	0.2 %YS (MPa)	% EL. (L=4d)	CVN Impact (J) at -40°C
SAF-8 LS	Typical	580.0	520.0	23.0	62

PACKAGING	STANDARD SIZE	Diameter 2.5mm, 3.2mm & 4.0 mm
	QUANTITY	<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>

**An ISO 9001: 2008 COMPANY**

**D&H Sécheron Electrodes Private Limited**

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