
	Autotherme Grade-E	
	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 (MOD)	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 (MOD)	Typical	520	568	24	140	124	110

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.

<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: tsd @dnhsecheron.net Website: www.dnhsecheron.com</p> <p style="text-align: right;">JUN 2017 (Rev.: 02)</p>
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