
	Autotherme Grade-E (Spl)	
	Copper coated solid wire for Submerged Arc Welding	

CLASSIFICATION: AWS: SFA 5.17
EH-12K

CHARACTERISTICS & APPLICATIONS :

Autotherme Grade-E (Spl) is a manganese-alloyed Copper coated wire for the Submerged Arc Welding of medium and high strength structural steels. Autotherme Grade-E (Spl) should preferably be used together with non-alloying or slightly alloying fluxes, such as Maxflux **SAF-8 (PW)** & Maxflux **SAF-8 (LS)**

CHEMICAL COMPOSITION OF SOLID WIRE, WT. %:

Element	C	Mn	Si	S	P	Cu
Range	0.06-0.15	1.50-2.00	0.25-0.65	0.025 Max	0.025 Max	0.35 Max
Typical	0.10	1.75	0.28	0.009	0.012	0.15

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, WT. %:

MAXFLUX	Element	C	Mn	Si	S	P	Cu
SAF-8 (PW)	Typical	0.090	1.62	0.35	0.010	0.018	0.10
SAF-8 LS	Typical	0.058	1.58	0.35	0.011	0.015	0.025

MECHANICAL PROPERTIES OF WELD METAL:

MAXFLUX	Property	0.2%YS (MPa)	UTS (MPa)	EI (L=4d) (%)	CVN Impact (J) at	
					-51 °C	-62 °C
SAF-8 (PW)	Typical	470	560	27	50	-
SAF-8 LS	Typical	450	550	28	68	-
SAF-8 (PW)	SR/620° C/2 HRS	460	545	30	70	35
SAF-8 (PW)	SR/620° C/7 HRS	430	525	32	55	30

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>	JUN 2017 (Rev.: 01)
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