
	<h2>Autotherme Grade-F</h2>	
	<p>Copper coated solid wire for Submerged Arc Welding</p>	

CODIFICATION: **AWS: SFA 5.23**
 EA-2

CHARACTERISTICS & APPLICATIONS:

Copper coated low alloy steel solid wires to be used with basic flux for welding of high tensile fine grain steel as well as steel which required high ductility. The weld metal has good elevated temperature properties and improved corrosion resistance features.

CHEMICAL COMPOSITION OF SOLID WIRE WT. %:

Element	C	Mn	Si	S	P	Mo	Cu
Range	0.05-0.17	0.95-1.35	0.20 Max	0.025 Max	0.025 Max	0.45-0.65	0.35 Max
Typical	0.12	1.10	0.16	0.020	0.021	0.50	0.20

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL WITH MAXFLUX SAF-223 WT. %:

Element	C	Mn	Si	S	P	Mo	Cu
Typical	0.07	1.38	0.59	0.018	0.022	0.47	0.15

MECHANICAL PROPERTIES OF ALL WELD METAL

Maxflux	Property	UTS (MPa)	0.2 %YS (MPa)	% EL. (L=4d)	CVN Impact (J) at -29°C
SAF-223	Typical	620.0	530.0	27	85

PACKAGING	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>
--