



Autotherme Grade-H



Copper Coated Solid Wire for Submerged Arc Welding

CODIFICATION: **AWS: SFA5.23**
ENi2

CHARACTERISTICS: Autotherme Grade-H Copper Coated solid wire for submerged arc welding. These are suitable for welding of similar composition steels.

APPLICATIONS: Copper coated solid wire used in single & multilayer welding of various steels. Especially suitable for welding of Pressure Vessels, Petrochemicals, Off-shore, refineries and railway industries etc.

CHEMICAL COMPOSITION OF SOLID WIRE WT. %:

Element	C	Mn	Si	S	P	Ni	Cu
Range	0.12 Max	0.75-1.25	0.05-0.30	0.020 Max	0.020 Max	2.10-2.90	0.35 Max
Typical	0.072	0.95	0.20	0.010	0.010	2.50	0.20

MECHANICAL PROPERTIES WITH MAXFLUX SAF-9.

Observed	UTS (MPa)	0.2 %YS (MPa)	% EL. (L=4d)	Impact CVN(J)	
				-46°C	-51°C
As Welded	695.0	620.0	19.7	80	60

Packing:	Standard Size	2.5, 3.2 & 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 certified company

D&H Sécheron Electrodes Private Limited

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