
	Autotherme Grade-J	
	Copper coated solid wire for Submerged Arc Welding	

CLASSIFICATION: AWS: SFA 5.23
EA4

CHARACTERISTICS & APPLICATIONS:

Autotherme Grade-J is a manganese-alloyed, copper coated wire for the submerged arc welding of medium and high strength structural steels. Autotherme Grade-J should preferably be used together with non alloying or slightly alloying fluxes.

CHEMICAL COMPOSITION OF SOLID WIRE, WT. %:

Element	C	Mn	Si	S	P	Mo	Cu
Range	0.05-0.15	1.20-1.70	0.20 Max	0.025 Max	0.025 Max	0.45-0.65	0.35 Max

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, WT. %:

MAXFLUX	Element	C	Mn	Si	S	P	Mo	Cu
723	Typical	0.075	1.54	0.18	0.018	0.023	0.52	0.15

**MECHANICAL PROPERTIES OF WELD METAL:
(PWHT AT 620°C FOR ONE HOUR)**

MAXFLUX	Property	0.2%YS (MPa)	UTS (MPa)	EI(L=4d) (%)	CVN Impact (J) at	
					-20°C	-30°C
723	Typical	528	608	27.2	105	88

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.: 01)</p>
