



Autotherme Grade-L

Copper coated solid wire for Submerged Arc Welding



CLASSIFICATION: AWS: SFA 5.23
EB2

CHARACTERISTICS

Autotherme grade-L wire is a copper coated 1.25Cr-0.5Mo solid wire for submerged arc welding. These wires are suitable for welding of creep resistance and similar composition high strength steels.

APPLICATIONS:

Autotherme grade-L wire is a suitable for welding of similar grade creep steels. The weld metal possesses good high temperature properties and meets radiographic quality Especially suitable for welding of pipes and tubes of matching compositions in power plants, refineries, petrochemicals, fertilizers plants etc. Suitable for welding of ASTM steels Grade F2, F11, F12, class 1 & 2 of SA-182, Grade T11 of SA-199, Grade T2, T11 & T12 of SA-213, GRADE WC6 OF SA-217, Grade P2, P11 & P12 of SA-335, Grade FP2, FP11 & FP12 of SA-369, Grade2, 11 & 12 of SA-387, Grade CP2,CP11 & CP12 of SA-426, and equivalent grade steels.

CHEMICAL COMPOSITION OF SOLID WIRE, %:

Element	C	Mn	Si	S	P	Cr	Mo	Cu
Range	0.07-0.15	0.45-1.00	0.05-0.30	0.025 Max	0.025 Max	1.00-1.75	0.45-0.65	0.35 Max

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL %:

MAXFLUX	Element	C	Mn	Si	S	P	Cr	Mo	Cu
SAF -13	Typical	0.06	0.78	0.21	0.009	0.020	1.10	0.52	0.21

**MECHANICAL PROPERTIES OF ALL WELD METAL:
(PWHT AT 690°C FOR ONE HOUR)**

MAXFLUX	Property	UTS(MPa)	0.2% YS(MPa)	%EI (L=4d)
SAF-13	Typical	637.2	559.2	24.4

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.

An ISO 9001: 2008 COMPANY

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