



Autotherme Grade-LR

Copper coated solid wire for Submerged Arc Welding



CLASSIFICATION: **AWS: SFA 5.23**
EB2R

CHARACTERISTICS

Autotherme Grade-LR Copper Coated Low Alloy Solid Wire for submerged arc welding specially designed for welding 1.25% Cr- 0.5% Mo steels. These wires are suitable for welding of creep resistant & similar composition of high strength steels. R designator is applicable for ultra low residuals, which results low Bruscato factor (X- Factor).

APPLICATIONS:

Autotherme Grade-LR low alloy solid wire is suitable for welding of various structural & Pressure vessel steels Main areas of application are associated with steam generating power plant, piping, turbine castings, steam chests, valve bodies and boiler super heaters like A387 Gr 11 & 12, A182 F11 & F12, A217 WC6 & WC11, A234 WP11 & WP12 A199 T11.

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 -12	Typical	0.070	0.71	0.32	0.009	0.009	1.21	0.52	0.13

**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 -12	Typical	580	490	23.0

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

D&H Sécheron Electrodes Private Limited
 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

JUN 2017 (Rev.: 03)