



Autotherme Grade-M

Copper coated solid wire for Submerged Arc Welding



CLASSIFICATION : AWS: SFA 5.23
EB3

CHARACTERISTICS

Autotherme grade-M is a copper coated 2.25Cr-1.0Mo solid wire for submerged arc welding. These wires are suitable for welding of creep resistance and similar composition high strength steels.

APPLICATIONS:

Autotherme grade-M filler wire suitable for welding of similar grade creep steels. The weld metal possesses good high temperature properties. It deposits notch free weld deposit with excellent mechanical properties especially suitable for welding of pipes and tubes of matching compositions in power plants, Refineries, Petrochemicals, Fertilizer etc. Suitable for welding of ASTM steels : Grade F22(class 1&3) of SA-182 & SA 336, Grade T4, T22 of SA-199, Grade T22 OF SA-213, GRADE WC9 OF SA-217, Grade P22 of SA-335, Grade FP22 Of SA-369, Grade22, 22L of SA-387, Grade CP22 of SA-426, Grade 22 of SA-541, Class 1 of A,B types of SA-542, etc.

CHEMICAL COMPOSITION OF SOLID WIRE, WT. %:

Element	C	Mn	Si	S	P	Cr	Mo	Cu
Range	0.05-0.15	0.40-0.80	0.05-0.30	0.025 Max	0.025 Max	2.25-3.00	0.90-1.10	0.35 Max

CHEMICAL COMPOSITION OF ALL WELD METAL, WT. %:

MAXFLUX	Element	C	Mn	Si	S	P	Cr	Mo	Cu
SAF-13	Typical	0.07	0.71	0.32	0.010	0.022	2.21	1.10	0.13

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

MAXFLUX	Property	UTS(MPa)	0.2% YS (MPa)	%EI (L=4d)
SAF-13	Typical	650.0	570.0	22.0

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

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