



Autotherme Grade-MR

Copper coated solid wire for Submerged Arc Welding



CLASSIFICATION : AWS: SFA 5.23 / EB3R

CHARACTERISTICS: Autotherme Grade-MR Copper Coated Low Alloy Solid Wire for Submerged Arc Welding specially designed for welding 2.25% Cr-1% 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-MR low alloy solid wire is suitable for welding of various structural & Pressure vessel steels. The weld metal possesses high temperature ability & excellent mechanical property. Main areas of application are associated with steam generating power plant, turbine castings, steam chests, valve bodies and boiler super heaters ASTM A387 Gr 21 & 22 A234 WP22 A199 T21, T22 A200 T21, T22 A213 T22A335 P22.

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-12	Typical	0.07	0.73	0.31	0.009	0.009	2.21	1.10	0.11

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

MAXFLUX	Property	UTS(MPa)	0.2% YS (MPa)	%EI (L=4d)
SAF-12	Typical	640.0	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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