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

CLASSIFICATION : **AWS: SFA 5.23**
EB9

CHARACTERISTICS: Autotherme grade-N is a copper coated 9%Cr-1.0%Mo solid wire for submerged arc welding. These wires are suitable for welding of creep resistance and similar composition high strength steels.

APPLICATIONS: Autotherme grade-N solid 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 A 213 T91, A 335 P91, A 387 Gr 91, A 182 / A336, A 217 C12A, A 234 WP91, A 369 FP91etc.

CHEMICAL COMPOSITION OF SOLID WIRE, WT. %:

Element	C	Mn	Si	S	P	Cr	Ni	Mo	V	Cu	Nb	N	Al
Range	0.07-0.13	1.25 Max	0.5 Max	0.010 Max	0.010 Max	8.50-10.50	1.0 Max	0.85-1.15	0.15-0.25	0.10 Max	0.02-0.10	0.03-0.07	0.04 Max

CHEMICAL COMPOSITION OF ALL WELD METAL WITH MAXFLUX SAF-12

Element	C	Mn	Si	S	P	Cr	Ni	Mo	V	Cu	Nb	N	Al
Typical	0.10	0.90	0.25	0.009	0.009	9.5	0.40	1.0	0.20	0.010	0.04	0.04	0.02

MECHANICAL PROPERTIES OF WELD METAL:
(PWHT AT 760°C FOR TWO HOURS)

MAXFLUX	Property	UTS(MPa)	0.2% YS (MPa)	%EI (L=4d)
SAF-12	Typical	680	575	21.0

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.

<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.: 04)</p>
