
	Autotherme Grade-S	
	Copper Coated Solid Wire for Submerged Arc Welding	

CODIFICATION: AWS: SFA5.23
ENi 3

CHARACTERISTICS:

Autotherme Grade-S Copper Coated with 3.5 % Ni solid wire for submerged arc welding. These are suitable for welding of similar composition high strength steels.

APPLICATIONS:

Autotherme Grade-S low alloy solid wire is suitable for welding of similar grade steels. The weld metal possesses high tensile strength, Excellent CVN toughness at -70 °C and meets the radiographic quality requirements. Especially suitable for welding of tubes matching composition in power plants, Refineries, Petrochemicals and Fertilizer Plants. Suitable for welding of ASTM steels: Grade ASTM A203Gr.E, ASTM A203Gr.D, ASTM A352 LC3 & ASTM A352 LC4 etc.

CHEMICAL COMPOSITION OF SOLID WIRE WT. %:

Element	C	Mn	Si	S	P	Cr	Ni	Cu
Range	0.13 Max	0.6-1.20	0.05-0.30	0.020 Max	0.020 Max	0.15 Max	3.10-3.80	0.35 Max

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

WITH MAXFLUX	Observed	UTS (MPa)	0.2 %YS (MPa)	% EL. (L=4d)	Impact CVN(J) at -70 °C
SAF-10	As Welded	600.0	500.0	24	40
	PWHT at 620°C for one hour	570.0	490.2	27	50

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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