



Autotherme WB36

Copper coated solid wire for Submerged Arc Welding



CLASSIFICATION: AWS A5.23/EG

CHARACTERISTICS:

Autotherme WB36 Copper coated solid wire for submerged arc welding application. A nominal composition of the wire is 1% Ni-0.5%Mo & Capable of achieving higher tensile strength.

APPLICATIONS:

Autotherme WB36 is a construction steel for service up to 450°C typical application designed on the basis of tensile strength. It is mainly used for standard carbon steels (ASTM Code Case 2353A335P36) in Conventional and nuclear power station. WB36 also finds applications for headers, manifolds and power stations.

CHEMICAL COMPOSITION OF SOLID WIRE, WT. %:

Element	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	V	Al
Range	0.08-0.15	1.3-2.4	0.25-0.35	0.010 Max	0.010 Max	0.10-0.20	0.8-1.2	0.2-0.3	0.30-0.60	0.007 Max	0.041 Max

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, WT. %:

MAXFLUX	Element	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	V	Al
SAF-WB36	Range	0.17 MAX	0.8-1.2	0.25-0.50	0.02 MAX	0.025 MAX	0.20 Max	1.0-1.3	0.35 MAX	0.5-0.8	0.010 Max	0.05 MAX
	Typical	0.080	1.1	0.42	0.012	0.023	0.16	1.1	0.30	0.73	0.007	0.02

MECHANICAL PROPERTIES OF WELD METAL:

MAXFLUX	Property	0.2%YS (MPa)	UTS (MPa)	EI (L=4d) (%)	CVN Impact (J) at -29°C
SAF WB-36	Typical	600	700	20	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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