



# Autotherme Grade-G



Copper Coated Solid Wire for Submerged Arc Welding

**CODIFICATION:**

**AWS: SFA5.23**  
**EG**

**CHARACTERISTICS:**

Autotherme Grade-G Copper Coated solid wire for submerged arc welding. These are suitable for welding of similar composition steels.

**APPLICATIONS:**

Copper coated solid wire used with Maxflux SAF-11 in single & multilayer welding of various weathering steels. Especially suitable for welding of Corten steels used in chemical, Petrochemicals and railway industries to resist atmospheric corrosion.

**CHEMICAL COMPOSITION OF SOLID WIRE WT. %:**

Element	C	Mn	Si	S	P	Cu
Range	0.10 Max	0.25-0.60	0.07 Max	0.030 Max	0.030 Max	0.35 Max

**MECHANICAL PROPERTIES WITH MAXFLUX SAF -11 FLUX**

Observed	UTS (MPa)	0.2 %YS (MPa)	% EL. (L=4d)	Impact CVN(J) -20° C
As Welded	570.0	480.0	24.0	45

Packing:	Standard Size	2.5, 3.2 & 4.0 mm
	Quantity	<ul style="list-style-type: none"><li>➤ 25 kg. wire in metallic ring.</li><li>➤ Identification-Brand name &amp; size is printed on label.</li><li>➤ Packed in corrugated cardboard box.</li><li>➤ 100Kg, 250kg, 500Kg &amp; 750kg Drum Packing also available on request.</li></ul>

**An ISO 9001: 2008 certified company**

**D&H Sécheron Electrodes Private Limited**

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