



Autotherme Grade-Q

Copper Coated Solid Wire for Submerged Arc Welding



CODIFICATION: **AWS: SFA5.23**
EM4

CHARACTERISTICS: Autotherme Grade-Q Copper Coated with 2.5 % Ni solid wire for submerged arc welding. These are suitable for welding of similar composition high strength & Quenched steels.

APPLICATIONS: Autotherme Grade-Q low alloy solid wire is suitable for welding of similar grade steels. The weld metal possesses high tensile strength, 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 A514, A517, A543 type B or C etc.

CHEMICAL COMPOSITION OF SOLID WIRE WT. %:

Element	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Range	0.10 Max	1.40- 1.80	0.20- 0.60	0.015 Max	0.010 Max	0.60 Max	2.0-2.80	0.30-0.65	0.25 Max

MECHANICAL PROPERTIES WITH MAXFLUX SAF -10

Observed	UTS (MPa)	0.2 %YS (MPa)	% EL. (L=4d)	Impact CVN(J) -60°C
As Welded	782.0.0	695.0	18.2	66

Packing:	Standard Size	2.5, 3.2 & 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 certified company

D&H Sécheron Electrodes Private Limited

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