



# Autotherme Grade-R

Copper Coated Solid Wire for Submerged Arc Welding



**CODIFICATION:**

**AWS: SFA5.23**  
**EB6**

**CHARACTERISTICS:**

Autotherme Grade-R Copper Coated solid wire for submerged arc welding. These are suitable for welding of similar composition high strength & Quenched steels.

**APPLICATIONS:**

Autotherme Grade-R 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 A213Gr.T5 A335 Gr.P5, A217 Gr.C5 etc.

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

Element	C	Mn	Si	S	P	Cr	Mo	Cu
Range	0.10 Max	0.35- 0.70	0.05- 0.50	0.025 Max	0.025 Max	4.50- 6.50	0.45- 0.70	0.35 Max

**MECHANICAL PROPERTIES WITH MAXFLUX SAF-12**

Observed	UTS (MPa)	0.2 %YS (MPa)	% EL. (L=4d)	CVN Impact (J) -20°C
PWHT / 745°C for 1 hr.	655.0	548.0	21.0	32

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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