



# Autotherme Grade-U (Mod)

Copper Coated Low carbon, high manganese high Silicon, ½ Moly special purpose wire for SAW



**CODIFICATION:**

**AWS: SFA5.23**  
**EA3K**

**CHARACTERISTICS:**

Autotherme Grade-U (Mod) Copper Coated Low carbon, high manganese high Silicon, ½ Moly special purpose wire for submerged arc welding. The wire gives good radiographic quality deposits with excellent crack resistance and toughness.

**APPLICATIONS:**

Autotherme Grade-U (Mod) is suitable for single, multi-pass welding especially Suitable for two run technique, suitable for similar composition C-Mo steels, fine grained steels and equivalent grade steels like: Gr. F1 of SA-182 and SA-336 Gr. A of SA-204, Gr. P1 pipe of SA-335, class 1 of A grade of SA-533, etc suitable for fabrication of heavy machinery, steel plant equipments & structures, high strength fabricated structures etc.

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

Element	C	Mn	Si	S	P	Mo	Cu
Range	0.05-0.15	1.60-2.10	0.50-0.80	0.025 Max	0.025 Max	0.40-0.60	0.35 Max

**MECHANICAL PROPERTIES WITH MAXFLUX SAF-723. [F8P8-EA3K-A3H8]**

Observed	UTS (MPa)	0.2 %YS (MPa)	% EL. (L=4d)	CVN Impact (J) -62°C
As Welded	630.0	556.0	22.0	>27
PWHT / 620 °C for 1 hr.	580.0	510.0	23.4	50

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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