
 Complete Welding Support	<h2>Mergearc Grade-J</h2>	
	<i>Copper coated solid wire for Submerged Arc Welding</i>	

CLASSIFICATION: AWS: SFA 5.23
EA4

CHARACTERISTICS & APPLICATIONS:

Mergearc Grade-J is manganese & molybdenum alloyed copper coated wire for the submerged arc welding of medium and high strength structural steels. Mergearc Grade-J should preferably be used together with non-alloying or slightly alloying fluxes.

CHEMICAL COMPOSITION OF SOLID WIRE, WT. %:

Element	C	Mn	Si	S	P	Mo	Cu
Range	0.05-0.15	1.20-1.70	0.20 Max	0.025 Max	0.025 Max	0.45-0.65	0.35 Max

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, WT. %:

MERGEARC	Element	C	Mn	Si	S	P	Mo	Cu
SAF-723	Typical	0.075	1.54	0.48	0.018	0.023	0.48	0.15

**MECHANICAL PROPERTIES OF WELD METAL:
(PWHT AT 620°C FOR TWO HOURS)**

MERGEARC	Property	0.2%YS (MPa)	UTS (MPa)	EI(L=4d) (%)	CVN Impact (J) at	
					-20°C	-30°C
SAF-723	Typical	528	608	27.2	105	88

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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