

AUTOTHERME GRADE-C

CODIFICATION: AWS/SFA 5.17 EN ISO 14171-B
EH14 SU41

CHARACTERISTICS AND APPLICATIONS:

Copper coated high medium-manganese, wire to be used in combination with basic type of flux for the welding of structural steel pressure vessel and boilers involving steels such as A-515 Gr.70, A-516 Gr.70, IS-8500 etc.

CHEMICAL COMPOSITION OF SOLID WIRE. WT (%):

ELEMENTS	C	Mn	Si	S	P	Cu
RANGE	0.10-0.20	1.70-2.20	0.10 Max	0.030 Max	0.030 Max	0.35 Max
TYPICAL	0.12	1.80	0.05	0.027	0.028	0.200

CHEMICAL COMPOSITION OF TYPICAL UNDILUTED WELD METAL. WT (%):

WITH SAW FLUX	C	Mn	Si	S	P	Cu
MAXFLUX SAF-4	0.13	1.80	0.38	0.028	0.027	0.150

MECHANICAL PROPERTIES OF TYPICAL WELD METAL:

WITH SAW FLUX	UTS (Mpa)	0.2% YS (Mpa)	% El (L = 4d)	CVN Impact (Joules)		
MAXFLUX SAF-4	530	418	26	90	75	45

APPROVALS: CE MARKING, IBR, BHEL

STANDARD SIZE: Diameters 2.50mm, 3.20mm, 4.00mm & 5.00mm.

ADDITIONAL INFORMATION:

Packing : 25Kg wire in metallic ring.
Identification : Brand Name & Size is printed on label.
Packing Types : 100Kg, 250Kg, 500Kg, 750Kg & Drum packing also on request

AUTHORISED DISTRIBUTOR - SALES & SERVICE

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