

AUTOTHERME GRADE-F

CODIFICATION: AWS/SFA 5.23 EN ISO 14171-B
EA2 SU2M3

CHARACTERISTICS AND APPLICATIONS:

Copper coated low alloy steel solid wires to be used with basic flux for welding of high tensile fine grain steel as well as steel which required high ductility. The weld metal has good elevated temperature properties and improved corrosion resistance features.

CHEMICAL COMPOSITION OF SOLID WIRE. WT (%):

ELEMENTS	C	Mn	Si	S	P	Mo	Cu
RANGE	0.05-0.17	0.95-1.35	0.20 Max	0.025 Max	0.025 Max	0.45-0.65	0.35 Max
TYPICAL	0.12	1.10	0.16	0.020	0.021	0.50	0.20

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

WITH SAW FLUX	C	Mn	Si	S	P	Mo	Cu
MAXFLUX SAF-223	0.07	1.38	0.59	0.018	0.022	0.47	0.15

MECHANICAL PROPERTIES OF TYPICAL WELD METAL:

WITH SAW FLUX	UTS (Mpa)	0.2% YS (Mpa)	% EI (L = 4d)	CVN Impact (Joules) -20°C	-29°C
MAXFLUX SAF-223	620	530	27	105	85

APPROVALS: CE MARKING

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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