

AUTOTHERME GRADE-N

CODIFICATION: AWS/SFA 5.23
EB9

CHARACTERISTICS AND APPLICATIONS:

Copper coated 9%Cr-1.0%Mo solid wire for submerged arc welding. These wires are suitable for welding of Creep resistance and similar composition high strength steels.

Autotherme grade-N solid wire suitable for welding of similar grade creep steels. The weld metal possesses good high temperature properties. It deposits notch free weld deposit with excellent mechanical properties especially suitable for welding of pipes and tubes of matching compositions in power plants, Refineries, Petrochemicals, Fertilizer etc. Suitable for welding of ASTM steels: Grade A 213 T91, A 335 P91, A 387 Gr 91, A 182 / A336, A 217 C12A, A 234 WP91, A 369 FP91 etc.

CHEMICAL COMPOSITION OF SOLID WIRE. WT (%):

ELEMENTS	C	Mn	Si	S	P	Cr	Mo	V	Ni	Nb	N	Al	Cu
RANGE	0.07-0.13	1.25	0.5	0.010	0.010	8.50-10.50	0.85-1.15	0.15-0.25	1.00	0.02-0.10	0.03-0.07	0.04	0.10
		Max	Max	Max	Max				Max			Max	Max

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

WITH SAW FLUX	C	Mn	Si	S	P	Cr	Mo	V	Ni	Nb	N	Al	Cu
MAXFLUX SAF-12	0.10	0.90	0.25	0.009	0.009	9.5	1.0	0.20	0.40	0.04	0.04	0.02	0.010

MECHANICAL PROPERTIES OF TYPICAL WELD METAL:

WITH SAW FLUX	UTS (Mpa)	0.2% YS (Mpa)	% EI (L = 4d)	CVN Impact (Joules) -20°C
MAXFLUX SAF-12	680	575	21.0	54

(PWHT : 760°C/2HRS)

APPROVALS: CE MARKING

STANDARD SIZE: Diameters 2.50mm, 3.20mm, 4.00mm

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

Head Office: Marn Burn Business Park | Suite No 900A | Block- BP | Salt Lake | Sector - V | Kolkata - 700091 | West Bengal | India

Regd. Office: 161/1 Mahatma Gandhi Road | Suite 83A | 3rd Floor | Kolkata - 700007 | West Bengal | India

info@crossmarketing.co.in | lakhotia.ravi@gmail.com | +91 89816 20042

<https://crossmarketing.co.in/>