AUTOTHERME GRADE-Q

Codification :

AWS SFA 5.23	EM4
EN ISO 26304-B	SUN5C1M3



Characteristics & Applications :

Copper coated with 2.5% Ni solid wire for submerged arc welding. These wires are suitable for welding of similar composition high strength & quenched steels. Autotherme Grade-Q low alloy solid wire is suitable for welding of similar grade steels. The weld metal possesses high tensile strength, and meets the radiographic quality requirements. Especially suitable for welding of tubes matching composition in power plants, Refineries, Petrochemicals and Fertilizer Plants. Suitable for welding of ASTM steels: Grade ASTM A514, A517, A543 type B or C etc.

Typical Chemical Composition Of Solid Wire (%) :

Element	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Range	0.10 Max	1.40 -1.80	0.20 0.60	0.015 Max	0.010 Max	0.60 Max	2.00 -2.80	0.30 0.65	0.25 Max
Typical	0.080	1.60	0.25	0.010	0.008	0.50	2.50	0.47	0.13

Typical Chemical Composition Of All Weld Metal (%) :

Element	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
MAXFLUX SAF-4 (UV)	0.07	1.68	0.36	0.010	0.012	0.40	2.48	0.50	0.13

Typical Mechanical Properties Of All Weld Metal :

(PWHT: 590°C FOR 3 HR)

SAW Flux	Properties	UTS (MPa)	0.2% YS(MPa)	%El (L=4d)	CVN Impact Strength (J)	
					-40°C	-46°C
MAXFLUX SAF-4 (UV)	Typical	795	665	27	78	58

Approvals : CE

Standard Size : Diameters 2.50mm, 3.20mm, 4.00mm

Additional Information :

Packing Data : 25Kg wire in metallic ring.

Identification : Brand Name & Size is printed on label.

Packing Types : 100Kg, 250Kg, 500Kg, 750Kg & Drum packing also on request.