



## AUTOTHERME-1223

**CODIFICATION:** AWS/SFA 5.14 ERNiCrMo-3

### CHARACTERISTICS AND APPLICATIONS:

Autotherme 1223 is a solid wire for MIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. Ideal for welding Ni-Cr-Mo alloys to themselves and to steel, and for surfacing steel. The wires are used in applications where the temperature ranges from cryogenic to 540°C. It also can be used for welding Ni base alloys to steel. Ideal for valves, valve seats, impellers, guide points, bushing, bearings, journals, hot working tools like hot shear blades, forging dies, trimming dies, piercing punches etc.

### TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	Cr	Ni	Mo	Fe	P	S	Al	Cu	Ti	Nb+Ta
%	0.06	0.40	0.30	21.0	61.0	9.0	4.0	0.015	0.008	0.2	0.25	0.2	3.5

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L = 4d) %
770	34.0

**SHIELDING GAS:** Argon

**CURRENT CONDITIONS:** DCEP

**WELDING POSITIONS:** H, F, VU, OH

### PACKING:

**STANDARD SIZE:** Diameter 0.8 mm, 1.2 mm & 1.6 mm

**QUANTITY** 12.5 kgs wire, layer wound in a plastic spool that conforms to DIN 8559 SD-300.