



AUTOTHERME GRADE-E

CODIFICATION: AWS/SFA 5.17 EN ISO 14171-B
EH10K SUN31

CHARACTERISTICS AND APPLICATIONS:

Copper coated High manganese special wire to be used in combination with acidic as well as basic flux for the welding of structural steels and fine grained steels requiring, 480 MPa tensile strength in the stress relieved conditions.

CHEMICAL COMPOSITION OF SOLID WIRE. WT (%):

ELEMENTS	C	Mn	Si	S	P	Cu
RANGE	0.07-0.15	1.30-1.70	0.05-0.25	0.025 Max	0.025 Max	0.350 Max
TYPICAL	0.10	1.55	0.21	0.010	0.013	0.20

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

WITH SAW FLUX	C	Mn	Si	S	P	Cu
MAXFLUX SAF-8 (LS)	0.08	1.55	0.21	0.010	0.013	0.15

MECHANICAL PROPERTIES OF TYPICAL WELD METAL:

WITH SAW FLUX	UTS (Mpa)	0.2% YS (Mpa)	% EI (L = 4d)	CVN Impact (Joules)		
				-29°C	-40°C	-46°C
MAXFLUX SAF-8 (LS)	568	520	24	140	124	110

APPROVALS: CE MARKING, BV, L&T

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

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