

# WIRES FOR SUBMERGED ARC WELDING OF HIGH STRENGTH STEELS



## COPPER COATED LOW ALLOY STEEL SOLID WIRES

CLASSIFICATION :			
Product	EN 14171	EN 26304-A	AWS A/SFA 5.23
AUTOMELT EF2			EF2
AUTOMELT EF3	S3Ni1Mo		EF3
AUTOMELT S3NiCrMo2.5		S3Ni2.5CrMo	EG

KEY FEATURES :	
<ul style="list-style-type: none"><li>Uniform copper coating</li><li>Smooth feeding</li></ul>	<ul style="list-style-type: none"><li>Close dimensional tolerances</li><li>Controlled Chemistry</li></ul>

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% (Typical, Including Cu in coating)							
Product	C	Mn	Si	Mo	Ni	Cr	Cu
AUTOMELT EF2	0.12	1.80	0.15	0.50	0.60		0.10
AUTOMELT EF3	0.12	1.75	0.20	0.55	0.90		0.10
AUTOMELT S3NiCrMo2.5	0.12	1.50	0.20	0.50	2.50	0.60	0.10

DIAMETERS - PACKING DATA :			
Product	Ø, mm	Kg / Spool	SAWPAC DRUM, Kg
AUTOMELT EF2	2.5, 3.15, 4.0, 5.0	25	350 / 500
AUTOMELT EF3	2.5, 3.15, 4.0, 5.0	25	350 / 500
AUTOMELT S3NiCrMo2.5	2.5, 3.15, 4.0, 5.0	25	350 / 500