



# C-Mn STEEL WIRES FOR SAW WELDING

COPPER COATED C-Mn STEEL SOLID WIRES

## CLASSIFICATION :

Product	EN 14171	AWS A/SFA 5.17
AUTOMELT EL8	S1	EL8
AUTOMELT EL12	S1	EL12
AUTOMELT EM12K	S2Si	EM12K
AUTOMELT EH10K	S3	EH10K
AUTOMELT EH12K	S3Si	EH12K
AUTOMELT EH11K		EH11K
AUTOMELT EH14	S4	EH14

## KEY FEATURES :

- Uniform copper coating
- Close dimensional tolerances
- Smooth feeding
- Controlled Chemistry

## CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% (Typical, Including Cu in coating)

Product	C	Mn	Si	Cu
AUTOMELT EL8	0.06	0.50	0.03	0.1
AUTOMELT EL12	0.09	0.50	0.03	0.1
AUTOMELT EM12K	0.09	1.00	0.20	0.1
AUTOMELT EH10K	0.08	1.40	0.15	0.1
AUTOMELT EH12K	0.10	1.55	0.25	0.1
AUTOMELT EH11K	0.09	1.50	0.90	0.1
AUTOMELT EH14	0.12	1.70	0.04	0.1

## DIAMETERS - PACKING DATA :

Product	∅, mm	Kg / Spool	SAWPAC DRUM, Kg
AUTOMELT EL8	1.6, 2.0, 2.5, 3.15, 4.0, 5.0	25	1.6 - 100 / 250 Others – 350 / 500
AUTOMELT EL12	1.6, 2.0, 2.5, 3.15, 4.0, 5.0, 5.50	25	1.6 - 100 / 250 Others – 350 / 500
AUTOMELT EM12K	1.6, 2.0, 2.5, 3.15, 4.0, 5.0	25	1.6 - 100 / 250 Others – 350 / 500
AUTOMELT EH10K	2.5, 3.15, 4.0, 5.0	25	350 / 500
AUTOMELT EH12K	2.5, 3.15, 4.0, 5.0	25	350 / 500
AUTOMELT EH11K	1.6, 2.0, 2.5, 3.15, 4.0, 5.0	25	1.6 - 100 / 250 Others – 350 / 500
AUTOMELT EH14	2.5, 3.15, 4.0, 5.0	25	350 / 500