

WIRES FOR SUBMERGED ARC WELDING OF CREEP RESISTANT STEELS



COPPER COATED LOW ALLOY STEEL SOLID WIRES

| CLASSIFICATION : | | | |
|------------------|----------|----------|----------------|
| Product | EN 14171 | EN 12070 | AWS A/SFA 5.23 |
| AUTOMELT EA2 | S2Mo | | EA2 |
| AUTOMELT EA3 | S4Mo | | EA3 |
| AUTOMELT EA4 | S3Mo | S MnMo | EA4 |
| AUTOMELT EB2 | | S CrMo1 | EB2 |
| AUTOMELT EB2R | | S CrMo1 | EB2R |
| AUTOMELT EB3 | | S CrMo2 | EB3 |
| AUTOMELT EB3R | | S CrMo2 | EB3R |
| AUTOMELT EB6 | | S CrMo5 | EB6 |
| AUTOMELT EB91 | | S CrMo91 | EB91 |

KEY FEATURES :

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

| CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% (Typical, Including Cu in coating) | | | | | | | |
|---|------|------|------|------|------|------|--|
| Product | C | Mn | Si | Cr | Mo | Cu | Other |
| AUTOMELT EA2 | 0.09 | 1.10 | 0.15 | | 0.50 | 0.10 | |
| AUTOMELT EA3 | 0.09 | 1.80 | 0.15 | | 0.50 | 0.10 | |
| AUTOMELT EA4 | 0.09 | 1.40 | 0.15 | | 0.50 | 0.10 | |
| AUTOMELT EB2 | 0.10 | 0.60 | 0.15 | 1.25 | 0.50 | 0.10 | |
| AUTOMELT EB2R | 0.10 | 0.60 | 0.15 | 1.25 | 0.50 | 0.10 | S-0.007; P-0.008; As-0.004; Sn-0.004; Sb-0.004; Bruscato factor X <15 |
| AUTOMELT EB3 | 0.10 | 0.60 | 0.15 | 2.40 | 1.00 | 0.10 | |
| AUTOMELT EB3R | 0.10 | 0.60 | 0.15 | 2.40 | 1.00 | 0.10 | S-0.007; P-0.008; As-0.004; Sn-0.004; Sb-0.004; Bruscato factor X <15 |
| AUTOMELT EB6 | 0.08 | 0.60 | 0.30 | 6.00 | 0.6 | 0.10 | |
| AUTOMELT EB91 | 0.10 | 0.40 | 0.25 | 9.00 | 1.00 | 0.07 | Ni-0.5; V-0.2; Nb-0.05; N-0.05; Al-0.005 |

DIAMETERS - PACKING DATA :

| Product | Ø, mm | Kg / Spool | SAWPAC DRUM, Kg |
|---------------|--------------------------|------------|-----------------|
| AUTOMELT EA2 | 2.0, 2.5, 3.15, 4.0, 5.0 | 25 | 350 / 500 |
| AUTOMELT EA3 | 2.5, 3.15, 4.0, 5.0 | 25 | 350 / 500 |
| AUTOMELT EA4 | 2.0, 2.5, 3.15, 4.0, 5.0 | 25 | 350 / 500 |
| AUTOMELT EB2 | 2.0, 2.5, 3.15, 4.0, 5.0 | 25 | 350 / 500 |
| AUTOMELT EB2R | 2.5, 3.15, 4.0, 5.0 | 25 | 350 / 500 |
| AUTOMELT EB3 | 2.0, 2.5, 3.15, 4.0, 5.0 | 25 | 350 / 500 |
| AUTOMELT EB3R | 2.5, 3.15, 4.0, 5.0 | 25 | 350 / 500 |
| AUTOMELT EB6 | 2.5, 3.15, 4.0, 5.0 | 25 | 350 / 500 |
| AUTOMELT EB91 | 2.5, 3.15, 4.0, 5.0 | 25 | 350 / 500 |