



AUTOTHERME 80S-D2

CODIFICATION: AWS : SFA 5.28 ER80S-D2

CHARACTERISTICS AND APPLICATIONS:

Autotherme 80S-D2 is a copper-coated solid wire for GMAW, available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. It is recommended for welding of molybdenum (~ 0.5%) containing high strength fine-grained structural steels. The wire also is suitable for welding of penstock pipe-line, fabrication of earth moving equipments, etc. where high tensile strength property is desired from the weld metal. Suitable for welding of ASTM steels: SA-455/SA-455M, Gr.60, Gr.65 steels of SA-515/SA-515M, Gr.60, Gr.65 steels of SA-516/SA-516M, Class 1 of A, B, C, D grades of SA-533/SA-533M, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Mo	Cu
%	0.075	1.78	0.55	0.014	0.015	0.45	0.15

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	YS	Elongation	CVN Impact Strength
(MPa)	(MPa)	(L=4d) %	At minus 30°C (Joules)
680	560	22	55

WELDING PARAMETER: DC(+)

Diameter	Flat	
	Volt, V	Current, A
1.2 mm	27-32	300-360
1.6 mm	25-30	340-420

SHIELDING GAS: Argon/ 1-5% O₂

WELDING POSITION: H, F, VU, OH

PACKING:

STANDARD SIZE 1.2 mm & 1.6 mm.

QUANTITY 15.0 kg wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.

Note: 1. The product satisfies the requirement of AWS SFA 5.28 ER90S-D2 class also.

2. Please check availability and minimum order quantity before placing the order.

AUTOTHERME C-Mo

CODIFICATION: AWS : SFA 5.28 ER70S-A1

CHARACTERISTICS AND APPLICATIONS:

Autotherme C-Mo is a copper-coated solid wire for GMAW, available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. It is ideally suited for welding of low alloy ferritic steels of similar composition. The weld metal possesses good high temperature properties. Typical applications include the welding of Carbon Molybdenum steels such as, ASTM Grade F1 of SA-182 & SA-336, Grade A of SA-204, Grade T1/T1a/T1b of SA-209, Grade WC1 of SA-217, Grade A of SA-302, Grade P1 of SA-335, Class 1 of A grades of SA-533, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Mo	Cu
%	0.065	1.20	0.45	0.010	0.012	0.55	0.10

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 620°C FOR 1 HR)

UTS	YS	Elongation
(MPa)	(MPa)	(L=4d) %
560	450	25.0

WELDING PARAMETER : DC(+)

Diameter	Flat	Current, A
	Volt, V	
1.20 mm	27-32	300-360
1.60 mm	25-30	340-420

SHIELDING GAS: Argon/ 1.5% O₂

WELDING POSITION: H, F, VU, OH

APPROVAL: CIB-MP

PACKING:

STANDARD SIZE	1.2 mm & 1.6 mm.
QUANTITY	15.0 kgs wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.



AUTOTHERME Cr-Mo 1

CODIFICATION: AWS : SFA 5.28 ER80S-B2

CHARACTERISTICS AND APPLICATIONS:

Autotherme Cr-Mo 1 is a copper-coated solid wire for GMAW, available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. It is suitable for welding 1.25Cr-0.5Mo steel. The weld metal possesses good high temperature properties. It deposits notch free weld deposit with excellent mechanical properties. Especially suitable for welding of pipes & tubes of matching composition in Power plants, Refineries, Petrochemicals, Fertilizer plants, etc. Suitable for welding of ASTM steels: Grade F2, F11, F12 class 1 & 2 of SA-182, Grade T11 of SA-199, Grade T2, T11 & T12 of SA-213, Grade WC6 of SA-217, Grade P2, P11 & P12 of SA-335, Grade FP2, FP11 & FP12 of SA-369, Grade 2, 11 & 12 of SA-387, Grade CP2, CP11 & CP12 of SA-426, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Mo	Cu
%	0.08	0.50	0.55	0.010	0.012	1.30	0.55	0.1

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 620°C FOR 1 HR)

UTS	YS	Elongation
(MPa)	(MPa)	(L=4d) %
620	550	24

WELDING PARAMETER : DC(+)

Diameter	Flat	
	Volt, V	Current, A
1.20 mm	27-32	300-360
1.60 mm	25-30	340-420

SHIELDING GAS : Argon/ 1-5% O₂

WELDING POSITION : H, F, VU, OH

APPROVAL : CIB-MP

PACKING :

STANDARD SIZE	1.2 mm & 1.6 mm.
QUANTITY	15.0 kg wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.

Note : Please check availability of drum packing before placing the order.

AUTOTHERME Cr-Mo 1 (MOD)

CODIFICATION: AWS : SFA 5.28 ER80S-B2

CHARACTERISTICS AND APPLICATIONS:

Autotherme Cr-Mo 1 (MOD) is a copper-coated solid wire for GMAW available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. This wire having lesser impurities i.e. S, P, will improve the subzero impact property. It gives radiographic quality welds. It is suitable for welding 1.25Cr - 0.5Mo steel. The weld metal possesses good high temperature properties. It deposits notch free weld deposit with excellent mechanical properties. Especially suitable for welding of pipes & tubes of matching composition in Power plants, Refineries, Petrochemicals, Fertilizer plants, etc. Suitable for welding of ASTM steels: Grade F2, F11, F12 class 1 & 2 of SA-182, Grade T11 of SA-199, Grade T2, T11 & T12 of SA-213, Grade WC6 of SA-217, Grade P2, P11 & P12 of SA-335, Grade FP2, FP11 & FP12 of SA-369, Grade 2, 11 & 12 of SA-387, Grade CP2, CP11 & CP12 of SA-426, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Mo	Cu	Sn	As	Sb
%	0.08	0.50	0.45	0.007	0.009	1.30	0.50	0.05	0.003	0.003	0.002

X-factor: $(10P + 5Sb + 4Sn + As) / 100 \leq 12$ ppm (elements in ppm)

J-factor: $(Mn + Si) \times (P + Sn) 10^4 \leq 120$

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 620°C FOR 1 HR)

UTS	YS	Elongation	CVN Impact Strength
(MPa)	(MPa)	(L=4d) %	At minus 20°C (Joules)
620	550	24	80

WELDING PARAMETER: DC(+)

Diameter	Flat	
	Volt, V	Current, A
1.2 mm	27-32	300-360
1.6 mm	25-30	340-420

SHIELDING GAS: Argon/ 1.5% O₂

WELDING POSITION: H, F, VU, OH

PACKING :

STANDARD SIZE 1.2 mm & 1.6 mm.

QUANTITY 15.0 kg wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.



AUTOTHERME Cr-Mo 2

CODIFICATION: AWS : SFA 5.28 ER90S-B3

CHARACTERISTICS AND APPLICATIONS:

Autotherme Cr-Mo 2 is a copper-coated solid wire for GMAW, available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. It is suitable for welding 2.25Cr - 1Mo steel. The weld metal possesses good high temperature properties. It deposits notch free weld deposit with excellent mechanical properties. Especially suitable for welding of pipes and tubes of matching composition in Power plants, Refineries, Petrochemicals, Fertilizer plants, etc. Suitable for welding of ASTM steels: Grade F22 (class 1 & 3) of SA-182 and SA-336, Grade T4, T22 of SA-199, Grade T22 of SA-213, Grade WC9 of SA-217, Grade P22 of SA-335, Grade FP22 of SA-369, Grade 22, 22L of SA-387, Grade CP22 of SA-426, Grade 22 of SA-541, Class 1 of A, B types of SA-542, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Mo	Cu
%	0.09	0.50	0.55	0.010	0.012	2.50	1.10	0.10

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 690°C FOR 1 HR)

UTS	YS	Elongation
(MPa)	(MPa)	(L=4d) %
680	600	19

WELDING PARAMETER: DC(+)

Diameter	Flat	
	Volt, V	Current, A
1.20 mm	27-32	300-360
1.60 mm	25-30	340-420

SHIELDING GAS: Argon/ 1-5% O₂

WELDING POSITION: H, F, VU, OH

APPROVAL: CIB-MP

PACKING:

STANDARD SIZE	1.2 mm & 1.6 mm.
QUANTITY	15.0 kg wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.

AUTOTHERME Cr-Mo 2 (MOD)

CODIFICATION: AWS : SFA 5.28 ER90S-B3

CHARACTERISTICS AND APPLICATIONS:

Autotherme Cr-Mo 2 (MOD) is a copper-coated solid wire for GMAW, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. This wire having lesser impurities i.e. S, P, will improve the subzero impact property. It gives radiographic quality welds. It is suitable for welding 2.25Cr - 1Mo steel. The weld metal possesses good high temperature properties. It deposits notch free weld deposit with excellent mechanical properties. Especially suitable for welding of pipes and tubes of matching composition in Power plants, Refineries, Petrochemicals, Fertilizer plants, etc. Suitable for welding of ASTM steels: Grade F22 (class 1 & 3) of SA-182 and SA-336, Grade T4, T22 of SA-199, Grade T22 of SA-213, Grade WC9 of SA-217, Grade P22 of SA-335, Grade FP22 of SA-369, Grade 22, 22L of SA-387, Grade CP22 of SA-426, Grade 22 of SA-541, Class 1 of A, B types of SA-542, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Mo	Cu	Sn	As	Sb
%	0.08	0.46	0.50	0.007	0.009	2.50	1.00	0.05	0.003	0.003	0.002

X-factor: $(10P + 5Sb + 4Sn + As) / 100 \leq 12$ ppm (elements in ppm)

J-factor: $(Mn + Si) \times (P + Sn) 10^4 \leq 120$

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 690°C FOR 1 HR)

UTS (MPa)	YS (MPa)	Elongation (L=4d) %	CVN Impact Strength At minus 20°C (Joules)
680	600	22	50

WELDING PARAMETER: DC(+)

Diameter	Flat Volt, V	Current, A
1.2 mm	27-32	300-360
1.6 mm	25-30	340-420

SHIELDING GAS: Argon/ 1-5% O₂

WELDING POSITION: H, F, VU, OH

PACKING :

STANDARD SIZE	1.2 mm & 1.6 mm.
QUANTITY	15.0 kg wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.



AUTOTHERME Cr-Mo 5

CODIFICATION: AWS : SFA 5.28 ER80S-B6

CHARACTERISTICS AND APPLICATIONS:

Autotherme Cr-Mo 5 is a copper-coated solid wire for GMAW, available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. It is suitable for welding 5Cr 0.5Mo steel. The weld metal possesses good high temperature properties. The weld metal possesses excellent creep property up to 550C. Especially suitable for welding of pipes and tubes of matching composition in Power plants, Refineries, Petrochemicals, Fertilizer plants, etc. Suitable for welding of ASTM steels: Grade F5/ F5a & F21 of SA-182, Grade T4, T22 of SA-199, Grade T22 of SA-213, Grade C5 of SA-217, Grade P22 of SA-335, Grade F5 & F21 (class 1&3) of SA-336, Grade FP5, FP21 of SA-369, Grade 5, 21 & 21L of SA-387, Grade CP5, CP21 of SA-426, Class 4, 4a of E types of SA-542, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Mo	Cu
%	0.06	0.50	0.40	0.010	0.012	5.20	0.55	0.10

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 745°C FOR 1 HR)

UTS	YS	Elongation
(MPa)	(MPa)	(L=4d) %
600	520	25

WELDING PARAMETER: DC(+)

Diameter	Flat	
	Volt, V	Current, A
1.20 mm	27-32	300-360
1.60 mm	25-30	340-420

SHIELDING GAS: Argon/ 1-5% O₂

WELDING POSITION: H, F, VU, OH

PACKING:

STANDARD SIZE	1.2 mm & 1.6 mm.
QUANTITY	15.0 kg wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.

AUTOTHERME Cr-Mo 9

CODIFICATION: AWS : SFA 5.28 ER80S-B8

CHARACTERISTICS AND APPLICATIONS:

Autotherme Cr-Mo 9 is a copper-coated solid wire for GMAW, available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. It is designed for creep resistant steels. It is used for welding base metal of similar compositions, usually in the form of pipe or tubing. Typical applications include welding of A387 Grade 9 plate, A335 P9 pipe, A213 T9 tubes, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Mo	Cu
%	0.08	0.60	0.30	0.020	0.020	9.00	1.00	0.10

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 745°C FOR 1 HR)

UTS	YS	Elongation
(MPa)	(MPa)	(L=4d) %
570	500	18

WELDING PARAMETER: DC(+)

Diameter	Flat	
	Volt, V	Current, A
1.2 mm	27-32	300-360
1.6 mm	25-30	340-420

SHIELDING GAS: Argon/ 1-5% O₂

WELDING POSITION: H, F, VU, OH

PACKING :

STANDARD SIZE	1.2 mm & 1.6 mm.
QUANTITY	15.0 kg wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.



AUTOTHERME Cr-Mo 91

CODIFICATION: AWS : SFA 5.28 ER90S-B9

CHARACTERISTICS AND APPLICATIONS:

Autotherme Cr-Mo 91 is copper-coated a solid wire for GMAW, yielding 9%Cr - 1%Mo and modified with Niobium, Vanadium and Nitrogen designed to provide improved creep strength, toughness, fatigue life, oxidation and corrosion resistance at elevated temperatures. The wire gives stable arc, smooth welding performance and deposits radiographic quality welds. It is designed to weld the materials in power plant, refineries, naptha cracker units, etc. Following are some of the steels that can be welded with this wire.

I) Plate: A 387 Gr.91 (II) Pipes: A 335-P91 (III) Tubes: A 213-T91

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	P	S	Cr	Ni	MO	V	Nb	N	Al	Cu
%	0.11	0.95	0.25	0.007	0.008	9.35	0.35	1.0	0.2	0.03	0.04	0.02	0.10

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 760°C FOR 2 HRS)

UTS	YS	Elongation
(MPa)	(MPa)	(L=4d) %
680	550	21

WELDING PARAMETER: DC(+)

Diameter	Flat	
	Volt, V	Current, A
1.20 mm	27-32	300-360
1.60 mm	25-30	340-420

SHIELDING GAS: Argon/ 5% CO₂

WELDING POSITION: H, F, VU, OH

PACKING :

STANDARD SIZE 1.2 mm & 1.6 mm.

QUANTITY 15.0 kgs wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.

Note : Please check the drum packing and minimum quantity required before placing the order.

AUTOTHERME Cr-Mo 92

CODIFICATION: AWS : SFA 5.28 ER90S-G

CHARACTERISTICS AND APPLICATIONS:

Autotherme Cr-Mo 92 is a copper-coated solid wire for GMAW, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. The weld metal content 9Cr-1Mo and enriched with Niobium, Vanadium, Nitrogen and tungsten. Tungsten additions provides adequate creep rupture strength at higher steam pressures and temperatures. The controlled addition of alloying elements improves the toughness and weldability. It is specially designed to weld advanced materials, which are being used to improve thermal efficiency in power plant, refineries etc. Ideal for welding steels of similar composition to achieve adequate creep rupture strength. Some typical materials where this electrode can be used are P92, Rotor Steel, E911 steels, GX12 Cr Mo WVNbW11 etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	P	S	Cr	Ni	Mo	V	Nb	N	Al	Cu	W
%	0.12	0.42	0.30	0.009	0.007	9.20	0.38	0.95	0.19	0.062	0.043	0.02	0.05	1.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 760°C FOR 2 HRS)

UTS	YS	Elongation
(MPa)	(MPa)	(L=4d) %
800	620	19

WELDING PARAMETER: DC(+)

Diameter	Flat	
	Volt, V	Current, A
1.2 mm	27-32	300-360
1.6 mm	25-30	340-420

SHIELDING GAS: Argon/5% Co₂

WELDING POSITION: H, F, VU, OH

PACKING:

STANDARD SIZE	1.2 mm & 1.6 mm.
QUANTITY	15.0 kg wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.

Note : Please check the drum packing and minimum quantity required before placing the order.



AUTOTHERME Mn-Mo

CODIFICATION: AWS : SFA 5.28 ER80S-G

CHARACTERISTICS AND APPLICATIONS:

Autotherme Mn-Mo is a copper-coated solid wire for GMAW, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. It is suitable for welding high strength fine-grained structural steels containing ~ 0.5%Mo. The wire is also suitable for welding of penstock pipe-line, fabrication of earth moving equipments, etc. where high tensile strength property is desired from the weld metal. Suitable for welding of ASTM steels: SA-455/ SA-455M, Gr.60, Gr.65 steels of SA-515/ SA-515M, Gr.60, Gr.65 steels of SA-516/ SA-516M, Class 1 of A, B, C, D grades of SA-533/ SA-533M, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Mo	Cu
%	0.06	1.75	0.53	0.010	0.015	0.40	0.15

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	YS	Elongation
(MPa)	(MPa)	(L=4d) %
640	540	23.0

WELDING PARAMETER: DC(+)

Diameter	Flat	
	Volt, V	Current, A
1.20 mm	27-32	300-360
1.60 mm	25-30	340-420

SHIELDING GAS: CO₂ / 80% Ar & 20 % CO₂

WELDING POSITION: H, F, VU, OH

PACKING:

STANDARD SIZE	1.2 mm & 1.6 mm.
QUANTITY	15.0 kg wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.

Note : Please check the availability and minimum order quantity before placing the order.

AUTOTHERME - 1

CODIFICATION: AWS : SFA 5.18 ER70S-6

CHARACTERISTICS AND APPLICATIONS:

Autotherme-1 is a copper coated mild steel GMAW wire for welding of mild steel, low carbon steel and other structural steels of tensile strength up to 540 MPa. The wire burns with smooth arc and minimum spatter under optimum welding conditions. It is designed for single and multi-pass welding of low and medium carbon steels like; SA-36, A/B/C/D grades of SA-283, A/B/C grades of SA-285, A/B grades of SA-414, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cu
%	0.09	1.60	0.90	0.018	0.018	0.15

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	YS	Elongation	CVN Impact strength
(MPa)	(MPa)	(L = 4d) %	at minus 30°C (Joules)
550	480	28.0	55

WELDING PARAMETER: DC(+)

Diameter	Flat	
	Volt, V	Current, A
0.80 mm	28-32	170-200
1.20 mm	27-31	260-290
1.60 mm	26-30	330-360

SHIELDING GAS: Co_2

WELDING POSITION: H, F, VU, OH

APPROVAL: Adani Infra, BHEL, BV, CIB-MP, L&T Power, NTPC

PACKING:

STANDARD SIZE	Diameter 0.8 mm, 1.2 mm & 1.6 mm
QUANTITY	12.5 / 15.0 kgs wire, random/ layer wound in a plastic spool that conforms to DIN-8559 SD-300.



AUTOTHERME 70S-2

CODIFICATION: AWS : SFA 5.18 ER70S-2

CHARACTERISTICS AND APPLICATIONS:

Autotherme 70S-2 is triple deoxidized copper coated mild steel wire for GMAW, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. It is suitable for mild steel pipes. Ideal for welding A36, A285 Grade C, A515-55, A516-70, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	P	S	Ti	Zr	Al	Cu	Ni	Cr	Mo
%	0.05	1.25	0.55	0.02	0.02	0.10	0.09	0.09	0.06	0.10	0.10	0.10

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L=4d) %	CVN Impact Strength At minus 30°C (Joules)
530	440	28.0	60

WELDING PARAMETER : DC(+)

Diameter	Flat	
	Volt, V	Current, A
0.8 mm	28-32	170-200
1.2 mm	27-31	260-290
1.6 mm	26-30	330-360

SHIELDING GAS: Ar / CO₂

WELDING POSITION: H, F, VU, OH

PACKING:

STANDARD SIZE	Diameter 0.8 mm, 1.2 mm & 1.6 mm
QUANTITY	15.0 kg wire, random/ layer wound in a plastic spool that conforms to DIN-8559 SD-300.

AUTOTHERME 70S-2 (NACE)

CODIFICATION: AWS : SFA 5.18 ER70S-2

CHARACTERISTICS AND APPLICATIONS:

Autotherme 70S-2 (NACE) is triple deoxidized copper coated mild steel wire for GMAW, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. It is designed for single and multi-pass welding of low and medium carbon steels. Ideal for welding A36, A285 Gr. C, A333 Gr.6, A515-55, A516-70, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	P	S	Ti	Zr	V	Al	Cu	Ni	Cr	Mo
%	0.05	1.25	0.55	0.010	0.008	0.10	0.09	0.01	0.09	0.06	0.10	0.10	0.10

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L=4d) %	CVN Impact Strength At minus 46°C (Joules)
530	440	28.0	45

CORROSION TEST: Passes corrosion test as per NACE standard TM-01-77-96 (SSCC) and TM-02-84-96 (HIC)

HARDNESS OF WELD METAL : 200 HV5 MAX.

WELDING PARAMETER : DC(+)

Diameter	Flat	
	Volt, V	Current, A
0.8 mm	28-32	170-200
1.2 mm	27-31	260-290
1.6 mm	26-30	330-360

SHIELDING GAS : Ar / CO₂

WELDING POSITION : H, F, VU, OH

PACKING :

STANDARD SIZE	Diameter 0.8 mm, 1.2 mm & 1.6 mm
QUANTITY	15.0 kg wire, random/ layer wound in a plastic spool that conforms to DIN-8559 SD-300.