

SAW Wires

Autotherme Grade-G

AWS: SFA 5.23 EGEN ISO CODE: 14171-B SU11

Autotherme Grade-G Copper Coated solid wire for submerged arc welding. These are suitable for welding of similar composition steels.



Copper coated solid wire used with Maxflux SAF-11 in single & multilayer welding of various weathering steels. Especially suitable for welding of Corten Steels used in chemical, Petrochemicals and railway industries to resist atmospheric corrosion.

Chemical Composition Of Solid Wire. Wt (%)

Element	C	Mn	Si	S	P	Cu
Range	0.10 Max	0.25-0.60	0.07 Max	0.030 Max	0.030 Max	0.350 Max

Chemical Composition Of Typical Undiluted Weld Metal.Wt (%)

WITH SAW FLUX	C	Mn	Si	S	P	Cu
MAXFLUX SAF-11	0.06	0.72	0.47	0.016	0.022	0.50

Mechanical Properties Of Typical Weld Metal

WITH SAW FLUX	UTS	0.2%YS	%EI	CVN Impact (J)	CVN Impact (J)	CVN Impact (J)
	(MPa)	(MPa)	(L=4d)	-20°C	-40°C	-46°C
MAXFLUX SAF-8 (LS) CTOD	570	480	24	45	-	-

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.