



# 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 EA2TiB			EG
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
<b>AUTOMELT EA2</b>	0.09	1.10	0.15		0.50	0.10	
<b>AUTOMELT EA3</b>	0.09	1.80	0.15		0.50	0.10	
<b>AUTOMELT EA4</b>	0.09	1.40	0.15		0.50	0.10	
<b>AUTOMELT EA2TiB</b>	0.09	1.10	0.15		0.50	0.10	Ti-0.1; B-0.013
<b>AUTOMELT EB2</b>	0.10	0.60	0.15	1.25	0.50	0.10	
<b>AUTOMELT EB2R</b>	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
<b>AUTOMELT EB3</b>	0.10	0.60	0.15	2.25	1.00	0.10	
<b>AUTOMELT EB3R</b>	0.10	0.60	0.15	2.25	1.00	0.10	S-0.007; P-0.008; As-0.004; Sn-0.004; Sb-0.004; Bruscato factor X <15
<b>AUTOMELT EB6</b>	0.08	0.60	0.30	6.0	0.6	0.10	
<b>AUTOMELT EB91</b>	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	Kg / Bobbin	SAWPAC DRUM, Kg
<b>AUTOMELT EA2</b>	2.0, 2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT EA3</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT EA4</b>	2.0, 2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT EA2TiB</b>	2.0, 2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT EB2</b>	2.0, 2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT EB2R</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT EB3</b>	2.0, 2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT EB3R</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT EB6</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT EB91</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500





# WIRES FOR SUBMERGED ARC WELDING FOR CRYOGENIC APPLICATIONS

COPPER COATED LOW ALLOY STEEL SOLID WIRES

## CLASSIFICATION :

Product	EN 14171	AWS A/SFA 5.23
Automelt ENi1	S2Ni1	ENi1
Automelt ENi2	S2Ni2	ENi2
Automelt ENi3	S2Ni3	ENi3
Automelt ENi5	--	ENi5

## 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	Ni	Cu	Mo
<b>AUTOMELT ENi1</b>	0.10	1.00	0.20	1.00	0.10	-
<b>AUTOMELT ENi2</b>	0.10	1.00	0.20	2.20	0.10	-
<b>AUTOMELT ENi3</b>	0.10	1.00	0.20	3.25	0.10	-
<b>AUTOMELT ENi5</b>	0.10	1.30	0.20	1.00	0.10	0.20

## DIAMETERS - PACKING DATA :

Product	Ø, mm	Kg / Spool	Kg / Bobbin	SAWPAC DRUM, Kg
<b>AUTOMELT ENi1</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT ENi2</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT ENi3</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT ENi5</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500





# 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 EF1	S2Ni1Mo		EF1
AUTOMELT EF2			EF2
AUTOMELT EF3	S3Ni1Mo		EF3
AUTOMELT EF4			EF4
AUTOMELT EF5			EF5
AUTOMELT S3NiCrMo2.5		S3Ni2.5CrMo	EG

## 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	Mo	Ni	Cr	Cu
AUTOMELT EF1	0.10	1.20	0.25	0.45	1.00		0.10
AUTOMELT EF2	0.12	1.80	0.20	0.50	0.60		0.10
AUTOMELT EF3	0.12	1.75	0.20	0.55	0.90		0.10
AUTOMELT EF4	0.18	0.80	0.25	0.25	0.60	0.50	0.10
AUTOMELT EF5	0.12	1.80	0.15	0.50	2.50	0.40	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	Kg / Bobbin	SAWPAC DRUM, Kg
AUTOMELT EF1	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
AUTOMELT EF2	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
AUTOMELT EF3	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
AUTOMELT EF4	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
AUTOMELT EF5	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
AUTOMELT S3NiCrMo2.5	2.5, 3.15, 4.0, 5.0	25	250	350 / 500





# WIRES FOR SUBMERGED ARC WELDING OF STAINLESS STEELS



STAINLESS STEEL SOLID WIRES

## CLASSIFICATION :

Product	EN ISO 14343-A	AWS A/SFA 5.9
SUBINOX 308L	S 19 9 L	ER308L
SUBINOX 308H		ER308H
SUBINOX 316L	S 19 12 3 L	ER316L
SUBINOX 309L	S 23 12 L	ER309L
SUBINOX 309LMo		ER309LMo
SUBINOX 347	S 19 9 Nb	ER347
SUBINOX 410	S 13	ER410
SUBINOX 410NiMo	S 13 4	ER410NiMo
SUBINOX 430	S 17	ER430
SUBINOX 2209	S 22 9 3 NL	ER2209
SUBINOX 2553		ER2553
SUBINOX 2594		ER2594

## KEY FEATURES :

- Smooth feeding
- Close dimensional tolerances
- Controlled Chemistry

## CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

Product	C	Mn	Si	Cr	Ni	Mo	Other Elements
<b>SUBINOX 308L</b>	0.025	1.50	0.40	19.5	9.3	--	--
<b>SUBINOX 308H</b>	0.05	1.50	0.40	19.5	9.2	--	--
<b>SUBINOX 316L</b>	0.025	1.50	0.40	18.5	11.5	2.2	--
<b>SUBINOX 309L</b>	0.025	1.50	0.40	23.5	12.2	--	--
<b>SUBINOX 309LMo</b>	0.025	1.50	0.40	23.5	12.2	2.2	--
<b>SUBINOX 347</b>	0.03	1.50	0.30	19.8	9.7	--	Nb + Ta – 0.60
<b>SUBINOX 410</b>	0.05	0.40	0.30	12.0	--	--	--
<b>SUBINOX 410NiMo</b>	0.03	0.40	0.30	12.0	4.5	0.45	--
<b>SUBINOX 430</b>	0.04	0.40	0.30	16.0	--	--	--
<b>SUBINOX 2209</b>	0.02	1.20	0.45	22.5	8.0	2.7	N – 0.12
<b>SUBINOX 2553</b>	0.02	0.60	0.40	25.0	5.5	3.5	Cu – 2.0
<b>SUBINOX 2594</b>	0.015	0.55	0.40	25.2	9.1	4.0	N – 0.25, W – 0.10







# WIRES FOR SUBMERGED ARC WELDING OF STAINLESS STEELS



STAINLESS STEEL SOLID WIRES

## DIAMETERS - PACKING DATA :

Product	Ø, mm	Kg / Spool	Kg / Bobbin	SAWPAC DRUM, Kg
SUBINOX 308L	0.8, 1.2, 1.6, 2.0, 2.5, 3.15, 4.0, 5.0	0.8 to 1.6 mm – 12.5 kg spool	2.0 to 5.0 mm - 250	0.8 to 1.6 – 100 & 250
SUBINOX 308H				
SUBINOX 316L				
SUBINOX 309LMo		1.6 to 5.0 – 25 kg Spool		2.0 to 5.0 - 350 & 500
SUBINOX 309L				
SUBINOX 347				
SUBINOX 410				
SUBINOX 410NiMo				
SUBINOX 430				
SUBINOX 2209				
SUBINOX 2553				
SUBINOX 2594				





# WIRES FOR SUBMERGED ARC WELDING OF NICKEL & NICKEL ALLOYS

NICKEL & NICKEL ALLOY SOLID WIRES

## CLASSIFICATION :

Product	AWS A/SFA 5.14
AUTOMELT NiCrMo3	ERNiCrMo3
AUTOMELT NiCrMo4	ERNiCrMo4

## KEY FEATURES :

- Smooth feeding
- Close dimensional tolerances
- Controlled Chemistry

## CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

Product	C	Mn	Fe	Si	Cr	Mo	Other Elements
<b>AUTOMELT NiCrMo3</b>	0.03	0.20	4.0	0.15	22.0	9.1	Nb-3.5; Al-0.1; Ti-0.1; Ni > 62.0
<b>AUTOMELT NiCrMo4</b>	0.01	0.60	5.0	0.03	15.0	16.0	W-4.0; Co-0.2; Cu- 0.01

## DIAMETERS - PACKING DATA :

Product	Ø, mm	Kg / Spool	Kg / Bobbin	SAWPAC DRUM, Kg
<b>Automelt NiCrMo3</b>	2.5, 3.15, 4.0, 5.0	25	250	350 & 500
<b>Automelt NiCrMo4</b>	2.5, 3.15, 4.0, 5.0	25	250	350 & 500

