

## Wires for Submerged Arc Welding of High Strength Steels

COPPER COATED LOW ALLOY STEEL SOLID WIRES

### CLASSIFICATION :

Product	EN 756	EN 12070	AWS A/SFA 5.23
AUTOMELT EF1	S2Ni1Mo		EF1
AUTOMELT EF2			EF2
AUTOMELT EF3	S3Ni1Mo		EF3
AUTOMELT EF4			EF4
AUTOMELT EF5		S3Ni2.5CrMo	EF5
AUTOMELT EG1			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
<b>AUTOMELT EF1</b>	0.10	1.20	0.25	0.45	1.00		0.10
<b>AUTOMELT EF2</b>	0.12	1.80	0.20	0.50	0.60		0.10
<b>AUTOMELT EF3</b>	0.12	1.75	0.20	0.55	0.90		0.10
<b>AUTOMELT EF4</b>	0.18	0.80	0.25	0.25	0.60	0.50	0.10
<b>AUTOMELT EF5</b>	0.12	1.80	0.15	0.50	2.50	0.40	0.10
<b>AUTOMELT EG1</b>	0.10	1.60	0.30	0.60	2.50		0.10

### DIAMETERS - PACKING DATA :

PRODUCT	Ø, mm	Kg / Spool	Kg / Bobbin	SAWPAC DRUM, Kg
<b>AUTOMELT EF1</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT EF2</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT EF3</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT EF4</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT EF5</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
<b>AUTOMELT EG1</b>	2.5, 3.15, 4.0, 5.0	25	250	350 / 500