

# 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
AUTOMELT ENi1	0.10	1.00	0.20	1.00	0.10	-
AUTOMELT ENi2	0.10	1.00	0.20	2.20	0.10	-
AUTOMELT ENi3	0.10	1.00	0.20	3.25	0.10	-
AUTOMELT ENi5	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
AUTOMELT ENi1	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
AUTOMELT ENi2	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
AUTOMELT ENi3	2.5, 3.15, 4.0, 5.0	25	250	350 / 500
AUTOMELT ENi5	2.5, 3.15, 4.0, 5.0	25	250	350 / 500