

EH14

AWS A5.17 EH14

Description:

EH14 is a copper coated carbon steel Submerged Arc Welding (SAW) contains high level of manganese, the bead metal with excellent mechanical properties when using with flux SJ101, SJ101Q, HJ431. Used for automatic submerged arc welding carbon steel and some alloy steel (like 16Mn, 14MnNb) structures.

Diameters:

2.0mm, 2.5mm, 3.2mm, 4.0mm, 5.0mm.

Typical Mechanical Properties:

Tensile strength(MPa):	554
Yield strength(MPa):	460
Elongation(%):	30
Impact values(≥ 47)/-20°C):	89

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Cu
0.090	1.75	0.016	0.012	0.005	0.01	0.010	0.07

Welding Current:

Dia:(mm)	2.0	2.5	3.2	4.0	5.0
Current/A	380-420	430-470	480-520	530-570	580-620
Voltage/V	28-32	28-32	28-32	28-32	28-32

Note:

1. Rusty, water, oil and other impurity should be cleaned before welding.
2. Flux should be bake 1-2 hours in 300-350°C before using.
3. According to the requirements to choose right welding parameter.