

EL12

AWS A5.17 EL12

Description:

EL12 is a copper coated mild steel wire for Submerged Arc Welding (SAW) of mild and medium carbon structural steels. Combined with flux HJ430 and HJ431, EL12 is used to weld low carbon steel and some low alloy steel (like 16Mn、Q235) structures.

Diameters:

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

Typical Mechanical Properties:

Tensile strength(MPa):	462
Yield strength(MPa):	370
Elongation(%):	32
Impact values(≥ 47)/(-20℃):	80

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0.054	0.42	0.012	0.010	0.12	0.01	0.014	--	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 200-250℃ before using.
3. According to the requirements to choose right welding parameter.