



UP EM4

Low Alloy Submerged Arc Wire

Classification

AWS A 5.23: ~EM4 mod EN 14295A: S3NiCrMo2.5

Charateristics

Solid copper coated wire for submerged arc welding, It is low alloyed wire recommended for welding wire for high strength structural steels.

Applications

For High strength low alloy wire with higher Mn-content for submerged arc welding of high yield strength and high tensile quenched and tempered fine grain steels in vessel and equipment construction. Welding of high strength pipe steels. EN10025, EN10028: SQ620 to S690QL. Pipe steels acc. To ISO 3183 EN 10208 and API -5: L625M/X90 to L690M/X100. Shipbuilding steels, upto 690MPa Yield strength.

Typical Wire Composition (%)

C	Si	Mn	Ni	Cr	Mo	P	S
0.10	0.17	1.50	2.35	0.50	0.45	0.010	0.010

All Weld Metal Mechanical Properties

Conditions	UTS Rm (MPa)	YS R _{p0.2} (MPa)	% Elg A=5d	Impact (kv) Temp. °C J	
AW UP BF 10	>820	>740	>18	- 60	>45

Parameters

Process	Wire Ø (mm)	Current (A)	Voltage (V)	Travel Speed (cm/min)	Flux
UP/SAW DC +ve	2.40	200 - 400	25 – 28	45 – 55	UP LA 04 UP LA05 UP BF10
	3.20	300 - 500	25 – 28	45 – 55	
	4.00	500 - 700	28 – 32	45 – 55	

Packing & Storage

25 kg Spool packed in Corrugated Cardboard Boxes. Wire to be Stored in dry conditions.

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