



UP S4Si

Copper coated Submerged Arc Wire

Classification

AWS A 5.17: EM14K

Characteristics

A Copper coated SAW wire containing a low Carbon (C), medium Manganese (Mn), medium Silicon (Si) and approximately 0.1% Titanium (Ti). Small addition of Titanium allows deposits to be stress-relieved with little loss of strength, even with extended stress relief times. Widely used with neutral basic fluxes or highly basic flux in both as-welded and post-weld heat treated conditions. with the UP BF 10 of neutral flux. It is capable of producing impact properties at -60°C (-80°F).

Applications

Applications include structural, Oil and gas and offshore steel work. For Sub zero application and for multi pass welding and for thick section of Carbon steels and fine grain steel.

Typical Wire Composition (%)

C	Si	Mn	Cu	Ti	P	S
0.10	0.43	1.20	0.15	0.05	0.018	0.012

All Weld Metal Mechanical Properties

Conditions	UTS	YS	% Elg	Impact (kv)	
	Rm (MPa)	R _{p0.2} (MPa)	A=5d	Temp. °C	J
AW UP BF 10	574	478	27	-60	65
PWHT UP BF10	555	432	29	-60	70

PWHT: 620°C /1hr.

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 LA04 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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Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended.

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