AWS A5.17: EM14K

High Manganese, High Silicon SAW Wire for Structural Welding

ULTRA EM14K

SUBMERGED ARC WIRE

CLASSIFICATION:

- AWS A5.17: EM14K
- · High-strength carbon-manganese steel wire
- Used with suitable flux for optimal performance
- · Ideal for structural and pressure vessel welding

TYPICAL APPLICATIONS:

- · Pressure vessel manufacturing
- · Pipe welding and fabrication
- · Ship hulls and marine structures
- · Heavy construction equipment
- · Steel bridge and tank fabrication

KEY FEATURES:

- Excellent weld bead appearance
- · Low spatter and smooth arc
- · Good mechanical properties

- · Compatible with various SAW fluxes
- · Reliable for critical structural joints

TYPICAL CHEMICAL COMPOSITION OF WIRE (%):

C - 0.12 Mn - 1.4 Si - 0.7 $S/P - \le 0.03$

MECHANICAL PROPERTIES OF WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (%)	Impact (J) at 0°C
580	480	29	85

PARAMETERS & PACKING DATA:

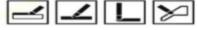
TAIGHTE TENO & LAONING PATA	
Diameter (mm)	Amperage Range (A)
2.5 / 3.2 / 4.0	350-750

DCEN(Electrode Negative)

Spools and drums available as per requirement. Ensure compatible flux for desired properties.

DCEN

Electrode Negative WELDING POSITION



USE: For thin sections