

ULTRA EM14K

SUBMERGED ARC WIRE

AWS A5.17: EM14K
High Manganese, High Silicon SAW Wire for Structural Welding

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 – ≤ 0.03
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MECHANICAL PROPERTIES OF WELD METAL:

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

PARAMETERS & PACKING DATA:

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**