



WELDING

UP EH14

Classification

AWS A5.17 : EH14

ISO 14171-A S4

Description & Applications

Copper coated solid wire for submerged arc welding of carbon and C-Mn steels.

Main applications: Steel constructions, pressure vessels, tanks...

Base material:

Construction steels for general use , Tube steels, Ship steels

EN	ASTM
S275 – S355	A106 grade A, B, C
P275 – P355	A131 grade A, B, D
L210 – L360	A139
	A210 grade A1, C
	A234 grade WPB
	A334 grade 1
	API 5LX42, 46, 52, 60

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Al	P	S	Fe
Min	0.10		1.75								
Max	0.15	0.15	2.20	0.15	0.15	0.15	0.30	0.030	0.025	0.025	Rem.
Type	0.13	0.05	2.0	0.05	0.05	0.01	0.15	0.005	0.010	0.008	Rem.

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters				Flux
		Current (A)	Voltage (V)	Stick out (mm)	Speed (cm/min)	
SAW	2.4	360 - 450	25 - 30	18	40 - 60	UP LA02
AC / =+	3.2	400 - 500	28 - 32	20	40 - 60	UP LA02.5
	4.0	500 - 600	30 - 35	22	50 - 60	

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