



# 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 AC / =+	2.4	360 - 450	25 - 30	18	40 - 60	UP LA02 UP LA02.5
	3.2	400 - 500	28 - 32	20	40 - 60	
	4.0	500 - 600	30 - 35	22	50 - 60	

FT En-SA04-171611

**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. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

[www.fsh-welding.com](http://www.fsh-welding.com) - [info@fsh-welding.fr](mailto:info@fsh-welding.fr)