



# UP EM12K

## Classification

AWS A5.17 : EM12K  
AWS A5.23 : EM12K

ISO 14171-A : S2Si

## 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, 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

## Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	Cu	Al	P	S
Min	0.07	0.15	0.80							
Max	0.15	0.35	1.25	0.15	0.15	0.15	0.30	0.030	0.025	0.025
Type	0.10	0.20	1.1	0.04	0.05	0.01	0.10	0.001	0.010	0.008

## 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 LA01
	3.2	400 - 500	28 - 32	20	40 - 60	UP LA02
	4.0	500 - 600	30 - 35	22	50 - 60	UP LA02.5
						UP LA03
						UP LA04
						UP LA05

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