

UN-EL08 SUBMERGED ARC WELDING WIRE 埋弧焊丝

Standard: AWS/ASME SFA-5.17 GB/T5293 H08A、H08E

Description: AP-EL08, is copper plated submerged welding wire used in the welding of low carbon structures, it is one of the most popular welding wires with the highest consumption in normal structure welding.

Chemical Composition Wire(%)

Item	C	Mn	Si	S	P	Cr	Cu	Ni
H08A	≤0.10	0.30-0.55	≤0.30	≤0.030	≤0.030	≤0.20	≤0.20	≤0.30
H08E	≤0.10	0.30-0.55	≤0.30	≤0.025	≤0.025	≤0.20	≤0.20	≤0.30

Mechanical Properties of Deposit Metal(based on GB/T5293 to combine AP-SJ501)

Test item	Tensile strength Mpa	Yield strength Mpa	Elongation %	Impact value (J)0℃	Value in average
Guaranteed	≥330	410-550	≥22	-20	≥27
Tested	400	520	28	-20	50

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Model Name	Standard	Chemical composition	Mechanical Properties	Description
UN-EM12	AWS/ASM SFA-5.17 EM12 GB/T5293 H08MnA	C≤0.10 Mn 0.8-1.10 Si≤0.07 S≤0.030 P≤0.030 Cr≤0.20 Cu≤0.20 Ni≤0.30	δ b 410-550MPa δ s ≥330MPa δ 5 ≥22% Akv(J) ≥27(-40℃)	EM12 A is a copper plated submerged welding wire used in the welding of low carbon structures, used with submerged welding fluxes(especially AP-SJ301,AP-SJ501,AP-SJ101, AP-SJ101G,AP-SJ101q,etc.series agglomerated, fluxes)in submerged welding, resulting in perfect deposit metal mechanical properties.
UN-EH14	AWS/ASM SFA-5.17 EH14 GB/T5293 H10Mn2	C≤0.12 Mn 1.5-1.9 Si≤0.07 S≤0.035 P≤0.035 Cr≤0.20 Cu≤0.20 Ni≤0.30	δ b 480-650MPa δ s ≥400MPa δ 5 ≥22% Akv(J)≥27(-40℃)	EH14 is a copper plated carbon structure submerged welding wire, used with submerged welding fluxes(especially AP-SJ301,AP-SJ501, AP-SJ101,AP-SJ101G,AP-SJ101q,etc.series agglomerated, fluxes)in submerged welding, resulting in perfect deposit metal mechanical properties.
UN-EM13K	AWS H10MnSiEM13K GB/T 5293 H10MnSi	C≤0.14 Mn 0.8-1.10 Si 0.60-0.90 S≤0.030 P≤0.030 Cr≤0.20	δ b 410-550MPa δ s ≥330MPa δ 5 ≥22% Akv(J)≥27(-20℃)	For welding important structures of low carbon steel and low-alloy steel, such as boilers, pressure containers, ships, nuclear power station, containers,bridges