

OK AUTROD 13.14

A Cu coated low alloyed solid wire for GMAW of HSLA steels

Classification AWS A5.28: ER90S-D2

DESCRIPTION

OKAUTROD 13.14 is a copper coated low alloyed wire for GMAW of HSLA steels. It is used for fabrication of tractor cylinder, automobile components and wagons. The wire is designed to produce excellent beads of radiographic quality in all positions. One of the significant applications of OK AUTROD 13.14 is of welding 'CONCOR' wagons of the Indian Railways

APPROVALS: RDSO

WELDING CURRENT: DC+

SHIELDING GAS: 100%CO₂ or 80%Ar/20%CO₂

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.10	YS (N/mm ²)	580
Si	0.60	UTS (N/mm ²)	690
Mn	2.00	Elongation (%)	24
Mo	0.45	Impact (CVN)	
Cu	0.25	@ -30°C (Joules)	45

CURRENT RANGE & PACKING DATA

Size (mm)	Current (Amp)	Voltage (V)	Packing in Kg.	
			12.5	15.0
1.2	80-280	18-28	✓	✓
1.6	120-360	20-34	✓	×

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5/15.0 kg.