Selectarc WELDING

SELECTARC UP EH14

SAW Wire

Classification

AWS A5.17 : EH14 ISO 14171-A : S4

Characteristics

UP EH14 is a versatile filler metal combination of Agglomerated or fused flux and solid wire for submerged arc welding (SAW) of butt and fillet joints. UP EH14 is more resistible to the rust and dirt of the base metal and thus offers excellent porosity resistance and X-ray soundness. The mechanical properties of multiple pass welds are consistent. Highly resistant at low temperatures, therefore also applied to weld 9% Ni steels.

Applications

In Ships, Industrial machinery, Pressure Vessels, Steel frames, and Bridges.

Typical Wire Composition (%)

C	Si	Mn	P	S	Cu	Fe
0.12	0.03	1.95	0.013	0.005	0.11	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R_m (MPa)	YS $R_{p0.2}$ (MPa)	% Elg A_5	Impact (KV) Temp.°C	J
AW	570	490	30	-51	59
PWHT	530	420	31	-51	64

PWHT : After heat treatment at 620°C / 1hr

Welding Current & Instructions

Ø (mm)	Polarity	Current (A)	Voltage (V)	Stick out (mm)	Flux
2.4	= +	200 - 400	28 - 32	~ 24	UP LA 04 / UP LA 05
3.2	= +	300 - 500	28 - 32	~ 32	
4.0	= +	500 - 700	29 - 33	~ 40	

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