



## EL-8 : DESCRIPTION

EL-8 is a copper coated mild steel electrode for Submerged Arc Welding (SAW) of mild and medium carbon structural steels.

## EM-12 : DESCRIPTION

EM-12 is a medium manganese alloyed copper coated steel wire for submerged arc welding and electroslag welding of medium and high tensile steels.

## EH-14 : DESCRIPTION

EH-14 is a copper coated manganese alloyed semi-killed electrode for Submerged Arc Welding (SAW) of medium and high tensile steels.

## Chemical Composition of Wire (%) :

Standard	C	Mn	Si	Cr	Ni	S	P	Cu
AWS EL-8	0.10	0.30-0.60	0.03	0.20	0.030	0.030	0.030	0.20
AWS EM-12	0.10	0.80-1.10	0.07	0.20	0.030	0.030	0.030	0.20
AWS EH-14	0.12	1.50-1.90	0.07	0.20	0.030	0.035	0.035	0.20

## Mechanical Properties of Weld Metal :

Standard	Yield point (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact V-Notch J (0°C)
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AWS EL-8	330	410-550	22	27
AWS EM-12	330	410-550	22	27
AWS EH-14	330	410-550	22	27

## Specification, Recommended Current Range and Package Weight :

Diameter (mm)	1.6	2.0	2.5	3.2	4.0	5.0
Current Range (A)	180-450	200-400	250-450	352-600	500-800	700-1000

25 Kg Coils with or without Paper / Metallic core.

