

STRONG EF4

CLASSIFICATION: AWS SFA 5.23 EF4

SAW Wire for High Strength Steels



CHARACTERISTICS & APPLICATIONS

STRONG EF4 is a medium carbon Mn-Ni-Cr-Mo alloyed, copper coated wire for the Submerged Arc Welding of similar composition high strength, quenched & tempered steels. The weld metal will possess high tensile strength & radiographic quality. Especially suitable for vessel construction & welding of pipes and tubes of matching compositions for power plants, refineries, petrochemicals, fertilizers plants etc.

TYPICAL WIRE CHEMISTRY (%)

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.16- 0.23	0.60- 0.90	0.15- 0.35	0.030 MAX	0.025 MAX	0.40- 0.60	0.40- 0.80	0.15- 0.30	0.35 MAX

PACKAGING SPECIFICATIONS - SAW SPOOL PACK

DIA SIZE	1.60MM / 2.00MM / 2.40MM / 3.15MM / 4.00MM / 5.00MM
SPOOL WEIGHT	25KGS / 30KGS

PACKAGING SPECIFICATIONS - DRUM PACK

DIA SIZE	1.60MM / 2.00MM / 2.40MM / 3.15MM / 4.00MM / 5.00MM
WEIGHT	150KGS / 250KGS / 300KGS / 350KGS / 500KGS

RECOMMENDED COMBINATION SAW FLUX

WIRE SIZE 2.40MM AND ABOVE	STRONG FLUX 10G / STRONG FLUX 62
WIRE SIZE 2.40MM AND BELOW	STRONG FLUX 16HS