



**FEAT CRAFT EM12K
SUBMERGED ARC WELDING WIRE**

**EXCELLENT WELDING PERFORMANCE AND
CHOICE FOR WIDE RANGE APPLICATION**



SPECIFICATION

AWS : A5.17 / EM12K

MECHANICAL OF PROPERTIES OF DEPOSITED METAL

| Wire | Condition | Yield Strength (Mpa) | Tensile Strength (Mpa) | Elongation (%) | CVN Impact (J) @ -20°C |
|-----------------|-----------|----------------------|------------------------|----------------|------------------------|
| AWS Requirement | As-welded | 388 | 501 | 29 | 68 |
| EM12K | | | | | |

CHEMICAL COMPOSITION – AS WELDED (%)

| C | Mn | Si | P | S | Ni | Cr | Cu |
|------|------|------|-------|-------|------|------|------|
| 0.08 | 0.91 | 0.04 | 0.018 | 0.012 | 0.01 | 0.02 | 0.15 |

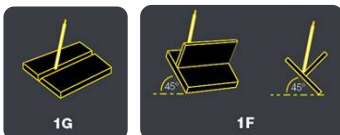
WELDING PARAMETER

| | TYPE OF CURRENT | AMPERE | VOLTAGE |
|--------|-----------------|----------|---------|
| RESULT | DC+ / AC | 300-650A | 26-32V |

PACKAGING AND CODE NUMBER

| Diameter (mm) | Packing | Weight (kgs) | Product Number |
|---------------|---------|--------------|----------------|
| 2.4 | Coil | 25 | EM12KCW25CT |
| 3.2 | | 200 | EM12KCW200T |
| 4.0 | | 300 | EM12KCW300T |
| 4.8 | | 700 | EM12KCW700IC |
| | | 900 | EM12KCW900IC |

Welding Position



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