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AUTOCRAFT SA2



- ▲ Copper Coated, Low Carbon Steel Submerged Arc Wire.
- ▲ Cost Effective General Purpose and Higher Quality Welding with a 'Neutral' Flux such as Satinarc.

TYPICAL WIRE ANALYSIS:

C: 0.10%	Mn: 1.0%	Si: 0.22%
S: 0.017%	P: 0.010%	

Classifications:

AS 1858.1: EM12K.
AWS/ASME-SFA A5.17: EM12K.

Description and Applications:

Autocraft SA2 is a copper coated - nominal 1.0% Manganese, 0.20% Silicon - steel submerged arc welding wire.

The chemical analysis of Autocraft SA2 makes it suitable for a wide range of general purpose and critical submerged arc welding applications with a 'neutral' fluxes such as Satinarc 4.

When used with this flux, Autocraft SA2 produces a high weld metal tensile strength.

Packaging and Operating Data*:

Wire Diameter mm	Current Range (amps)	Voltage Range (volts)	Recommended Stickout (ESO) mm	Pack Type	Pack Weight	Part No
2.4	250-700	26-34	20-25	Coil	25kg	720663
3.2	300-900	28-34	25-30	Coil	30kg	720664



- ▲ Semi-Basic Submerged Arc Flux.
- ▲ For Multi Pass Butt Welding Applications Requiring Low Temperature Impact Properties.
- ▲ Recommended for Use with Autocraft SA2.
- ▲ Excellent Slag Lift in Deep 'Vee' Joints.

Classifications:

AWS A5.17:	F7A4-EM12K.
AWS A5.17:	F6P4-EM12K.
AS 1858.1:	EM12K-FMM-W503A.

Description and Applications:

Satinarc 4 is a semi-basic, agglomerated flux suitable for a wide range of fillet and butt welding applications.

It is recommended for heavier, multi-pass butt welding applications and produces excellent slag lift in narrow joint preparations.

The Autocraft SA2 / Satinarc 4 combination provides consistent 'as welded' and 'stress relieved' mechanical properties. Despite its basic slag system, Satinarc 4 produces good weld profiles, edge wetting and slag lift in single and multi-pass welding applications.

Operating Capabilities:

Satinarc 4 flux produces smooth arc characteristics and excellent slag lift in deep 'vee' weld preparations.

Weld beads will exhibit a fine rippled surface appearance and smooth side wall wash.

Satinarc 4 operates well with AC or DC power and is tolerant to lightly rusted or scaled plate.

Autocraft SA2 / Satinarc 4

APPROVALS:

Lloyds Register of Shipping - Grade 3M 3YM

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.09%	Mn: 1.2%	Si: 0.4%
S: 0.020%	P: 0.030%	

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES (AS WELDED):

Yield Stress	425 MPa.
Tensile Stress	520 MPa
Elongation	29%
CVN Impact Values	100 J av @ -20°C.
	140 J av @ 0°C.

Flux Constituents:

(Basicity Index* = 1.6

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
20%	25%	35%	15%

* Basicity Index to Boniszewski.

Packaging Data:

Pack Type	Pack Weight	Part No
4 Ply Paper Bag	25kg net	720412

