



GB/T 5293 H10Mn2
AWS A5.17 EH14
EN ISO 14171-AS42 4 FBS4

AK EH14

Description: EH14 is a copper-plated low-sulfur-phosphorus high manganese buried arc welding wire, which matches the welds of low manganese and silicon. The welding process has excellent performance. The arc combustion is stable, the residue is easy, and the weld is beautiful.

Application: It cooperates with the melting welding HJ330, HJ350, HJ431, or sintering welding SJ101, SJ102, SJ105 and other alloy steels for welding carbon steel, boiler, pressure vessels, bridges, ships, etc.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	Cu
Requirement	0.10	0.07	1.50-1.90	0.015	0.020	—	—	—	—
Actual Result	0.065	0.30	1.47	0.008	0.013	—	—	—	—

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	480-650	≥400	22	27J(-40℃)
Actual Result	601	516	30	115