THM-43 (EL8)

SUBMERGED ARC WELDING WIRE

AWS A5.17 EL8
GB/T 5293 SU08A

APPLICATION

430 MPa class carbon steel structures, including SA-36/Gr.D.

CHARACTERISTICS

THM-43 (EL8) is a copper-coated solid wire for automatic submerged arc welding with a suitable flux. Mechanical properties apply to the flux-wire combination specified for the test.

PRECAUTIONS

Remove rust, oil, moisture, and other contaminants before welding. Heat input affects deposited weld metal mechanical properties; lower heat input is recommended.

MECHANICAL PROPERTIES

Items	Tensile strength (MPa)	Yield strength (MPa)	Elongation (%)	Impact energy at -20 °C (J)
Requirements	430-600	≥330	≥20	≥27
Typical results	460	375	28	80

The mechanical property values shown in the specifications apply to the TH.SJ301/THM-43 flux-wire combination.

WIRE CHEMICAL COMPOSITION (%)

Items	C	Mn	Si	S	P	Cr	Ni	Cu
Requirements	≤0.10	0.40-0.65	≤0.03	≤0.030	≤0.030	≤0.20	≤0.30	≤0.35
Typical results	0.07	0.48	0.01	0.013	0.015	0.01	0.02	0.10

CERTIFICATION

CCS · RINA

Applies to the TH·SJ301 + THM-43 flux-wire combination.

BRIDGE WELDING MATERIALS