

# Premierweld™ IN61

AWS EM12K



Premierweld™ IN61 is a low carbon, medium manganese, medium silicon general purpose submerged arc welding wire. It produces welds with tensile strength 5 - 15ksi higher than those with EL-12 depending on the flux and procedures used.

It's construction is simple, the wire is wrapped around a paperboard tube. The reusable adaptor allows a coil to fit on the industry standard 50mm hub.

## KEY FEATURES

- ▶ Consistent weld deposit chemistry and procedure from package to package improve quality and save time.
- ▶ Has no soft spots, set the welding procedure once and forget about them.
- ▶ Thin copper coating yields significantly improved electrical contact between wire and contact tip for better stability and longer tip life.
- ▶ Low feed force help to reduce wear and tear on equipment.
- ▶ Can be used with 780, 960, P223, BF-1 fluxes.

## APPLICATIONS

- ▶ Construction Equipment
- ▶ Agricultural Equipment
- ▶ Pressure Vessel
- ▶ General Fabrication
- ▶ All Heavy Welding Applications

## CONFORMANCE

AWS A5.17

EM12K

## DIAMETERS / PACKAGING

Diameter (mm)	Coils (Kg)	Drums (Kg)	Product No.
2.5	30		ICS61250
3.2	30		ICS61320
4.0	30		ICS61400
3.2		250	ICS61322
4.0		250	ICS61402
4.8		250	ICS61485

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## TYPICAL CHEMICAL COMPOSITION, ELECTRODE

	%C	%Mn	%Si	%P	%S
Requirements AWS A5.17 EM12K	0.05 - 0.15	0.80 - 1.25	0.10 - 0.35	0.030 max	0.030 max
Typical Values	0.089	0.920	0.272	0.016	0.006

## TYPICAL CHEMICAL COMPOSITION, ALL WELD METAL

	%C	%Mn	%Si	%P	%S
Requirements A5.17 F7A2-EM12K	-	-	-	-	-
Typical Values	0.051	1.346	0.448	0.024	0.007

## MECHANICAL PROPERTIES, ALL WELD METAL

	Tensile Strength MPa	Yield Strength MPa	Elongation (%)	Charpy V-Notch J @ -29°C
Requirements A5.17 F7A2-EM12K	481 - 653	398	22 min	27
Typical Values	543	451	31	36

### TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

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