



Application/properties:

is used for welding fine-grained steels used in pressure vessels, boilers, pipes and storage tanks. Its weld metal has high toughness and low hydrogen content. This electrode has a stable and concentrated arc and is therefore suitable for positional welding. Its weld is of good quality in terms of radiographic examination.

Weld metal analysis in % (typical values):

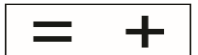
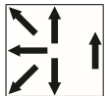
C	Mn	Si	Ni	S	P
٠,٠٧	١,٤	٠,٤	٠,٩	< ٠,٠٢	< ٠,٠٢

Mechanical Properties of all-weld metal:

(single values are typical values)

Tensile Strength (N/mm ^٢)	Yield Strength (N/mm ^٢)	Elongation A٥ (%)	Impact energy (J) ISO-V -٤٠°C
٥٨٠	٤٨٠	>٢٤	١٣٠

Welding Parameters		
Diameter (mm)	Length (mm)	Amperage (A)
٢,٥	٣٥٠	٦٥ - ٩٥
٣,٢٥	٣٥٠ - ٤٥٠	٩٠ - ١٣٠
٤,٠	٣٥٠ - ٤٥٠	١٤٠ - ١٨٠
٥,٠	٤٥٠	١٨٠ - ٢٤٠



Remarks:

- Just Consume Dry Electrode
- Rebaking: required on ٣٠٠°C to ٣٥٠°C for ٢ hours.