

Universal construction electrode (root passes)

GENERAL DESCRIPTION

Electrode for welding steels with tensile strength up to 520 N/mm² (75ksi).
 Universal use.
 Easy arc ignition and a stable arc.
 Excellent slag control, smooth beads and slag can easily be removed.
 Can be used for root passes in pipe welding.

APPLICATIONS

All structural fabrication and repair works.
 Structural steel: S185, S235 - S355 (EN 10025).
 Boiler plate: P235GH, P265GH, P295GH (EN 10028-2).
 Pipe steel: P235T1 - P355N (EN 10217-1); P235T2 - P355N (EN 10217-3); StE290.7TM - StE480.7TM (EN 10208-2).
 API steel: X42 - X70 and fine grain steel: StE355 - StE460 (EN 10028-3).
 Hull steel grade A, B, D, E, AH32 - EH36.
 Cast steel GS38 - GS45.
 Construction of boilers and pressure vessels.
 Excellent for welding pipelines and making root passes.

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C : 0.06 – 0.10	Mn : 0.35 – 0.70	Si : 0.30 – 0.60	P : < 0.02	S : < 0.02
Fe : Balance				

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 420 MPa	500 - 640 MPa	≥ 20 %	≥ 47 J (0°)

GENERAL INFORMATION

Welding positions	All				
Shielding gas	NA				
Packing	5 Kg in a cardboard box				
Polarity	AC or DC, straight polarity (electrode negative)				
Diameter (mm)	2.0	2.5	3.2	3.2	4.0
Length (mm)	350	350	350	450	450
Approx. current (A)	40 - 70	60 - 90	85 - 130	85 - 130	120 - 170

Tips & Tricks

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.