

**High strength****GENERAL DESCRIPTION**

Welding electrode for fillet welds in horizontal, overhead and vertical-up positions.  
 The weld bead is smooth and finely rippled. The electrode has the ability to make welds of longer run-length at high welding speed.  
 Weld deposit with high strength and toughness.  
 The smaller diameters are suitable for thin plate welding.

**APPLICATIONS**

Assembling and repair welding for boiler- and bridge construction and shipbuilding etc...

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

C : 0.07	Mn : 0.70	Si : 0.50	P : < 0.025	S : < 0.025
Fe : Balance				

**MECHANICAL PROPERTIES (Typical values, all weld metal)**

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 420 MPa	500 - 640 MPa	≥ 22 %	≥ 47 J (0°)

**GENERAL INFORMATION**

<b>Welding positions</b>	All					
<b>Shielding gas</b>	NA					
<b>Packing</b>	5 Kg in a cardboard box					
<b>Polarity</b>	AC or DC, straight polarity (electrode negative)					
<b>Diameter (mm)</b>	2.0	2.5	3.2	3.2	4.0	4.0
<b>Length (mm)</b>	350	350	350	450	350	450
<b>Approx. current (A)</b>	40 - 70	90 - 110	110 - 140	110 - 140	120 -190	120- 190

**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.*