

High efficiency electrode**GENERAL DESCRIPTION**

Electrode for fillet welding and butt welding of construction steel at high travel speed. Because the deposit is twice as fast as with multilayer techniques with conventional rutile electrodes, the shrinking force that could lead to twisting or distortion is minimized. Long beautiful welding beads; slag easy to remove. Efficiency: 160 %.

APPLICATIONS

Filling V-grooves and fillet welds.
Steel and cast steel with tensile strength up to 520 N/mm².

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

C : 0.06 – 0.10	Mn : 0.60 – 0.80	Si : 0.40 – 0.60	P : < 0.025	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	≥ 520 MPa	≥ 23 %	≥ 70 J (20°C)

GENERAL INFORMATION

Welding positions	PA, PB, PC		
Shielding gas	NA		
Packing	5 Kg in a cardboard box		
Polarity	AC or DC, straight polarity (electrode negative)		
Diameter (mm)	3.2	4.0	5.0
Length (mm)	450	450	450
Approx. current (A)	120 - 180	180 - 220	260 - 320

Tips & Tricks
Weld with short or medium arc length.
Can be welded with dragging or weaving technique.
The electrode is kept slightly inclined in the direction of the weld.