

## Exceptional weldability

### GENERAL DESCRIPTION

Basic type electrode for quality butt welds in constructions under high restraint.  
 Exceptional weldability; either AC or DC can be used.  
 High elongation and impact strength.  
 Smooth deposit, finely rippled.  
 The slag can easily be removed. Re-strike is very easy.

### APPLICATIONS

All vehicles, frames of motor lorries, chassis repairs, shafts of trailers, reservoirs and pipelines.  
 All highly restrained constructions, especially cold bended profiles.  
 Welding of structural steel St34-St60, boiler plate HI-HIV, 17Mn4, 19Mn5, pipe steel St35-St52, St35.4-St52.4, St35.8-St45.8, StE210.7-StE385.7, hull steel A, B, D, fine grained steel StE255-StE355, WStE255 - WStE355 and cast steel GS38-GS60.

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

C : 0.05 – 0.10	Mn : 0.80 – 1.20	Si : 0.50 – 0.70	P : < 0.02	S : < 0.02
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)
≥ 380 MPa	470 - 600 MPa	≥ 20 %	≥ 47 J (-20°C)

### GENERAL INFORMATION

<b>Welding positions</b>	All, except vertical down.			
<b>Shielding gas</b>	NA			
<b>Packing</b>	5 Kg in a plastic box			
<b>Polarity</b>	AC or DC, reverse polarity (electrode positive) – for root pass use straight polarity			
<b>Diameter (mm)</b>	2.5	3.2	4.0	5.0
<b>Length (mm)</b>	350	350	450	450
<b>Approx. current (A)</b>	60 - 85	90 - 130	120 - 180	160 - 240

#### Tips & Tricks

Use a short arc, keep the electrode at an angle of 90° to the work piece.  
 To avoid porosity, strike the electrode on a spare piece of metal and bring it back at the end of the weld without extinguishing the arc.  
 Operate the same way for each new weld.  
 At the end of each weld, come back with the electrode on the deposit to avoid the formation of a crater.  
 Always use very dry electrodes to obtain the highest possible mechanical characteristics.  
 Dry at 300 °C (570 °F) for not less than 2 hours.

*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.*