

Electrode with excellent weldability**GENERAL DESCRIPTION**

Special steel electrode for badly prepared parts and wide open joints.
 Very easy to use.
 Smooth weld appearance in all positions.
 Low open circuit voltage, making arc ignition very easy.
 Can be used with all welding machines.
 Can be used for tack welding.
 The slag is self-releasing.

APPLICATIONS

Construction of boilers and machines.
 For universal use in badly prepared constructions.
 Welding of low- and unalloyed cast steel.

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

C : 0.06 – 0.10	Mn : 0.40 – 0.70	Si : 0.35 – 0.70	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)
≥ 400 MPa	490 - 550 MPa	≥ 24 %	≥ 50 J (20°C)

GENERAL INFORMATION

Welding positions	All		
Shielding gas	NA		
Packing	5 Kg in a plastic box		
Polarity	AC or DC, straight polarity (electrode negative)		
Diameter (mm)	2.5	3.2	4.0
Length (mm)	350	350	350
Approx. current (A)	60 - 90	100 - 120	140 - 160

Tips & Tricks
 For well-prepared joints: weld with short arc or in contact.
 For badly prepared joints: limit the size of the weldpool by interrupting the arc.