

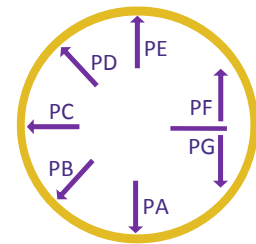
Applications

General Fabrication

Features

- Suitable for butt and fillet welding of thin plates
- Good restriking
- Good bead appearance
- Easy slag removal
- Smooth arc and low fume
- AC welding with low ocv

Welding Position



Typical Chemical Properties of All-Weld Metal (%)

C	Si	Mn	P	S
0.05	0.2	0.35	0.022	0.017

Typical Mechanical Properties of All-Weld Metal

Ys Mpa (Kg/in)	TS Mpa(Kg/in)	EL (%)	Temp °C	CVN- Impact Value J
439 (63,700)	488 (70,900)	26.8	0 (32)	67 (50)

Diameter mm (in)	2.6 (3/32),	3.2 (1/8),	4.0 (5/32),	5.0 (3/16)
Length mm (in)	350 (14),	450 (18),	450 (18),	450 (18)
F & HF	50-95	80-130	120-180	160-230
V-up, OH	45-90	60-120	100-160	120-220

Notes on Usage

- Preheating between 100 and 200°C is necessary before welding.
- Be sure to remove moisture, oil and rust on the base metal.

Packing Details

5Kg Pack / 20 Kg Ctn (Corrugated Pack)