

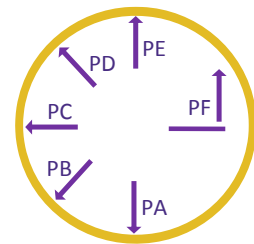
Applications

- Heavy steel fabrication
- Low temperature strength steel
- Offshore structure

Features

- Suitable for butt and fillet welding of thin and medium-thick plates (up to 20mm)
- Iron powder and low hydrogen type electrode (high efficiency)
- Good impact value at -45°C

Welding Position



Typical Chemical Properties of All-Weld Metal (%)

C	Si	Mn	P	S
0.06	0.25	1.25	0.017	0.011

Typical Mechanical Properties of All-Weld Metal

Ys MPa	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN- Impact Value J
480	550	30.2	-45	94

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	60-90	90-140	130-190	180-240
V-up, OH	50-80	80-120	120-170	150-200

Current

AC or DC +

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Notes on Usage

- Be sure to remove moisture, oil and rust on the base metal.
- To avoid blowholes when striking the arc, please use back step method during welding
- Keep short arc length when welding.

Packing Details

4Kg Pack / 16 Kg Ctn (Vacuum Packing)