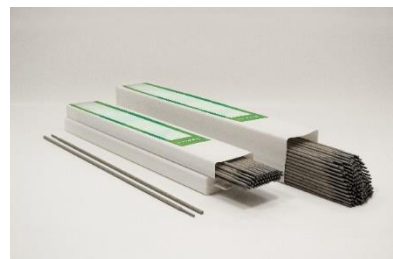


DOUBLE COATED BASIC ELECTRODES (STEEL)

#item	EAN	MDM	Dimensions
853718	3660338097430	9249474	2.5 x 350 / 152 Units
853719	3660338097447	9249128	3.2 x 350 / 91 Units
853720	3660338097454	9249110	4.0 x 450 / 55 Units



Description

Basic coated electrode presenting exceptional welding characteristics due to its double coating. Arc very stable in all positions, almost spatter free, easy removal of the slag. Universal use for welding metal constructions and for repairing. Recommended for root passes and on badly prepared joints too.

Base materials

Construction steels for general use, Tube steels, Ship steels, Steels for Boiler and Pressure Vessels, High strength steels, Heat resisting steels, Cold tough steels

Désignation-EN	S185 – S355	P235 – P355
	GP240R	P235GH – P265GH
	L210 – L360	
Tôles navales	Qualité A,B, C et D	
ASTM	A285 grade C	A414 grade C, D, E, F
	A442 grade 55, 60	A515 grade 55, 60, 65, 70
	A516 grade 55, 60, 65, 70	

Typical Weld Metal Composition (%)

C	Si	Mn	P	S	Fe
<0.10	0.7	0.9	<0.02	<0.02	Base

All Weld Metal Mechanical Properties

Re (MPa)	Rm (MPa)	As (%)	KV (J)
450	550	27	+20°C 150 -20°C 80

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x450
Intensité	(A)	80	115	150

Redrying: 2h at 300°C, if necessary. Interpass temperature: < 250°C.

Classification

AWS A5.1 : E7016

ISO 2560-A : E 38 2 B 12 H10

EN 499 : E 38 2 B 12 H10