

Processing information

Welding positions:



Polarity:



Application

Electrode for joint welding at very high welding speed in engineering, steel construction and ship building. It is especially suitable for cover passes. This stick electrode is characterised by fine drop transfer, flat concave fillets and easy slag removal.

Field



**Characteristic
acidic-coated**

Standards
ISO 2560-A
E 35 0 A 13
AWS A 5.1
E 6027

Approvals



Materials	
Construction steels	S235 - S275
Ship steels	A, B, D
Boiler steels	P195 - P275
Pipe steels	L210 - L245
Cast steels	GE200,GE240,GP240
Reinforcing steels	BSt 420

All Weld Metal Mechanical Properties		
Heat Treatment	AW	
Weld Metal Composition [%]		
C	Si	Mn
0,1	0,1	0,5
Yield Strength Re [MPa]	> 370	
Tensile Strength Rm [MPa]	440-510	
Elongation A5 [%]	> 22	
Charpy Impact Value ISO-V [J/0°C]	> 70	

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.970.324*	3,25/450	110 - 140	6,0	133	45,1
00.970.404*	4,00/450	130 - 170	6,0	91	65,9
00.970.504*	5,00/450	170 - 210	6,0	59	101,7

* This product is not a standard stock article. All dimensions are produced only to customer order. Ask for an individual quotation.



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