FACTS

Application

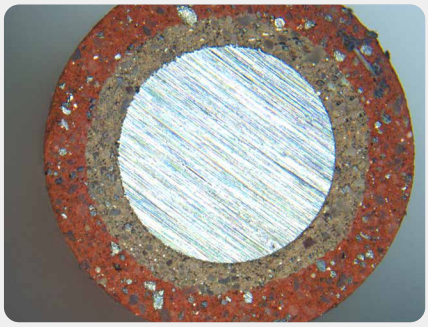
- Joint welding in constrained positions
- Unalloyed and low-alloyed steels
- Assembly and repair welding

Advantages

- High mechanical properties
- Yield strength > 430 MPa
- Slag easily removable
- Very stable arc
- Smooth weld seams
- Suitable for alternating current

Standards

DIN EN ISO 2560-A: E42 2 B 12 H10
AWS A5.1: E 7016



Basic coating outside, rutile cover inside

DUOWELD

Qualified double-coated electrode for unalloyed and low-alloyed steels

Due to its excellent welding properties and easy handling, the double coated stick electrode DUOWELD is suitable as a universal welding filler metal in all areas of industry and trade, especially in general mechanical engineering, steel construction, boiler construction and shipbuilding.

The special structure of the electrode with two coating materials with different properties combines the advantages of a rutile coating with the high strength values of basic electrodes. A concentrated and stable arc is the basis for the outstanding for the excellent suitability for constrained layers and for X-ray safe root layers.

Technical data		
Typical analysis	C Si Mn	0,08 % 0,5 % 1,1 %
Yield strength	Re	≥ 430 MPa
Tensile strength	Rm	≥ 490 MPa
Elongation	A5	≥ 25 %
Notched-bar impact value	ISO-V	≥ 60 J /-30 °C

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