

Key Facts

- Excellent arc stability
- Designed for single sided "butt" joint root run
- Suitable for high tensile steels
- Tough weld metal

Description

Low hydrogen type, covered electrode for mild steel and 490N/mm² high tensile strength steel. Good arc stability, slag removability and smooth weld beads.

Classifications

ASME/AWS A5.1 E7016
EN499 E422B
JIS Z3211 D4316

Welding Positions

All positions excluding vertical down

Applications

Designed specifically for root runs on one side welding of pipes and general structures.

- Structural steel
- Pipe "butt welds"
- Pressure vessels
- Rural maintenance and fabrication

Typical Analysis/Composition

C - Carbon	Si - Silicon	Mn - Manganese	P - Phosphorus	S - Sulphur
0.05 - 0.10	<0.75	<1.60	< 0.020	< 0.02

Typical Weld Mechanical Properties

0.2% Proof Stress	Tensile Strength	Elongation
> 400N/mm ²	> 480N/mm ²	> 22%

Packaging & Ordering Information

Size	Weight	Part Number
2.6mm	5kg	100053
3.2mm	5kg	100054
4.0mm	5kg	100055