

Classifications

EN ISO 2560-A:2006 : E 38 0 A 23
 AWS A5.1-04 : E6022

Description

- Covering is high iron oxide type for welding of flat and horizontal fillet welding of sheet metal.
- Highly efficient welding.
- Welding under excessive amperage conditions can cause the deterioration of radiographic soundness.
- Redry the electrode at 70~100°C for 30~60 minutes prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.14	0.28	1.20	0.025	0.012	0.02	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				RT	0°C	
AWS A5.1		min. 430				
EN ISO 2560-A	min. 380	470~600	min. 20		≥ 47	
Example	450	480	26	75	55	AW

※ AW : As-Welded

Sizes available and recommended currents (AC or DC -)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp. (A)	F V · OH	60~110	80~140	160~200	180~240	260~320

Approvals

JIS, CE