

DESCRIPTION

Double coated basic CTOD-tested electrode with excellent welding properties in difficult positions. This electrode provides good arc stability and is very suitable for welding root runs with DC and AC current.

CLASSIFICATION

EN ISO 2560 - A	E 42 4 B 12 H 10
DIN 1913	E 51 43 B (R) 10
AWS A-5,1	E 7016
EN 499	E 42 4 B 12 H 10

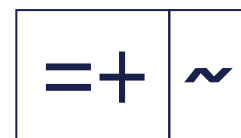
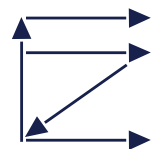
MECHANICAL PROPERTIES

R_m	500 - 600 N/mm ²
R_p	> 420 N/mm ²
A_5	>22%
A_v	>47 J(-40 °C)

WELDING PARAMETERS

Ø (mm)	Amp. (A)
2.00	55 - 65
2.50	60 - 90
3.25	90 - 140
4.00	140 - 190
5.00	190 - 250
6.00	250 - 320

OPERATING DATA



RE-DRY:
380°C / 1h

APPROVALS

DNV

