

**Applications**

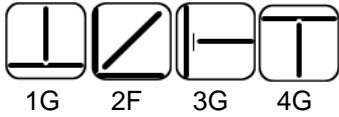
Used for welding rusty plates, structural fabrication. Used for tacking works, repair. Construction equipments. Steel furniture, Truck bodies, storage tanks.

**Characteristics on Usage**

A general purpose, rutile coated electrode, designed for welding application of structural fabrication and repair works. The electrode is running in all position and has medium penetration of welding characteristics, it can be used to weld rusty plates and poor joints fitup. It produces a flat evenly rippled weld bead, with easily removable slag.

**Notes On Usage**

- 1) Dry electrode at 70-100 °C for 30-60 min.before use.
- 2) Pay attention not to exceeds the range of proper current.

**Welding Positions****Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%
0.20 Max	1.20 Max	1.00 Max	0.030 Max	0.030 Max

**Mechanical Properties Of Weld Metal**

U.T.S.	Y.S.	ELONGATION	IMPACT ( CVN )
(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	( L = 4d ) %	AT +27° C ( J )
450 Min	350 Min	17 % Min	50 Joules Min

**Approvals****Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	285	1140	AC / DC (-)	60 – 90
3.15 x 450	150	600		100 – 140
4.00 x 450	110	440		140 - 180
5.00 x 450	75	300		180 - 230