

Semi-basic coated electrode designed for the welding and reinforcing of ferritic - austenitic steels and for steels with a difficult weldability. It has excellent mechanical properties and is highly resistant to high temperature cracks. It is suitable for many applications, and recommended for repairs and maintenance.

## Classification

EN 1600 / ISO 3581-A : E 29 9 R 2  
AWS A 5.4 : E 312-16

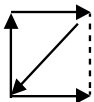
## Applications

- Universal use for repairs and maintenance,
- Carbon steel,
- Galvanised steel,
- Tool steel,
- Manganese steel,
- Use on dissimilar steel.

## Benefits

- Soft arc.
- The weld bead aspect.
- Easy slag removal .
- High resistance to cracks.

## Positions and polarity



- Ignition from 50V - Direct current.
- **Electrode polarity (+).**

## Chemical properties

C %	Mn %	Si %	S %	Cu %	Ni %	Cr %	Mo %
0.10	1.20	0.20	0.015	0.05	10.00	30.00	0.10

## Mechanical properties

Rs	Rm	A 5 d	KV 0 °C
450 MPa	680 MPa	25%	60 J

## Recommendations

Ø electrode (mm)	2.0	2.5	3.2
thickness (mm)	2 ▶ 4	3 ▶ 6	8 ▶ +
welding current (A)	30 ▶ 60	40-80	70-100



## Packaging

Ref.	Ø (mm)	length (mm)	
081475	Ø 2.5	300	54
081468	Ø 3.2	350	28