

B-14

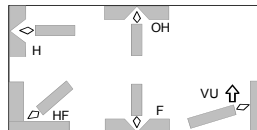
Ilmenite type covered electrode for mild steel

Classification: ASME / AWS A5.1 E6019
EN499 E352RA
JIS Z3211 D4301

Features : •Suitable for butt and fillet welding of thin and middle-thick plates (up to 20mm)
•Excellent usability

Redrying conditions: 70~100°Cx0.5~1h

Welding Positions:



Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S
Example	0.10	0.10	0.43	0.015	0.007
Guaranty	0.05~0.13	0.05~0.25	0.25~0.65	≤0.030	≤0.025

Mechanical properties of all-weld metal as per AWS

	YP (MPa)	TS (MPa)	EI (%)	IV (J)
Example	410	460	32	-18°C: 82
Guaranty	≥330	≥410	≥22	-18°C≥27

Recommended welding parameters

	2.6mm	3.2mm	4.0mm	5.0mm	6.0mm
Dia.	2.6mm	3.2mm	4.0mm	5.0mm	6.0mm
F, HF, H	55~90A	85~140A	130~190A	180~260A	240~310A
VU, OH	45~75A	60~120A	100~160A	135~210A	-

Polarity

Example	AC
Guaranty	AC, DC-EP, DC-EN

Approvals

AB	LR	NV	BV	NK	Others
3	3m	3	3	KMW3	CR

Packages

Dia. (mm)	Length (mm)	Weight per pack(kg)	Weight per carton(kg)	Weight per piece(g)
2.6	350	5	20	20
3.2	400	5	20	35
4.0	450	5	20	62
5.0	450	5	20	94
6.0	450	5	20	141