

## Key Facts

- Smooth running electrode
- Easy to strike
- One amperage for a range of positions

## Description

A titanium oxide covered electrode for welding mild steel. The arc is stable with little splatter resulting in a beautiful bead appearance. Ideal for downward welding in the vertical position. Due to shallow penetration it is also useful for welding steel sheets and light structures.

High titania oxide type covered electrode. Used for general fabrication work on AC or DC  $\pm$ . A popular choice as arc is stable with little spatter. Downhand welding in the vertical position becomes easy with this rod & results in beautiful bead appearance.

## Classifications, Approvals and Conformances

ASME/AWS A5.1 E6013  
EN499 E350R  
JIS Z3211 D4313

## Welding Positions

All positions excluding vertical down

## Applications

Used for general fabrication work. Suitable for steel furniture, plates, fences, gates, pipes and tanks. Also used to weld sheet steel structures in ships, railway vehicles and cars.

- General welding
- Galvanised steels
- Thin sheet or tubing
- Rural maintenance and fabrication
- Ship repairs

## Typical Analysis/Composition

C - Carbon	Si - Silicon	Mn - Manganese	P - Phosphorus	S - Sulphur
0.05 – 0.12	0.15 – 0.45	0.25 – 0.65	< 0.030	< 0.025

## Typical Weld Mechanical Properties

0.2% Proof Stress	Tensile Strength	Elongation
> 330N/mm <sup>2</sup>	> 410N/mm <sup>2</sup>	> 17%

## Packaging & Ordering Information

Size	Weight	Part Number
2.6mm	5kg	100039
3.2mm	5kg	100040
4.0mm	5kg	100041
5.0mm	5kg	100042

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.