

AI-0111

Specifications

AS/NZS 1553.1 : E4112-0

AWS/ASME A5.1 : E 6013

DIN 1913 E 43 2/2 R11

Description and Applications

A universal electrode especially developed for use in the maintenance field for welding in all positions (including Vertically Down) of badly prepared sheets of steel of all thicknesses, badly adjusted joints and of steel contaminated by paint, corrosion etc. Electrode has the feature of being able to be used on welding sets operating on very low open circuit voltages. Other features include very smooth stable arc, easy strike and re-strike and automatic slag removal.

Typical Weldmetal Analysis

C	Mn	Si	Fe
0.07	0.5	0.3	Bal

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	550MPa
Yield Strength (0.2%)	480MPa
Elongation	24% (4d)
Charpy V	50J @ 0°C 35J @ -10°C

Welding

Diameter (mm)	Current type	Amps
2.0	DC /AC	50-80
2.5	DC /AC	70-90
3.25	DC /AC	110-130
4.0	DC /AC	130-150
5.0	DC /AC	150-180

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (3G, 3F, 5G up) Vertical Position Up, (3G, 3F, 5G down) Vertical position down

Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at sales@alloysint.com.au



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