

FERROCRAFT 21

 45
OCV

 DC
AC

- ▲ Rutile Type, Medium Iron Powder Electrode.
- ▲ Excellent Operator Appeal!
- ▲ Versatile - All Positional Capabilities.
- ▲ Easy Striking - Hot or Cold!
- ▲ Ideal for Vertical Down Fillet Welding.
- ▲ Reliable Impact Toughness to -20°C.

Classifications:

AS/NZS 1553.1: (old) E4814-2.
 AS/NZS 4855: (new) B E4914 A U
 AWS/ASME-SFA A5.1: E7014.

Description and Applications:

Ferrocraft 21 is a popular rutile type, medium iron powder electrode developed and manufactured in Australia by CIGWELD. It offers many features including smooth stable AC / DC running on low O.C.V. welding machines, excellent fillet shapes in all welding positions (including vertical-down/up and overhead) and a higher electrode efficiency of 110%. In addition, Ferrocraft 21 produces good radiographic quality, a self releasing slag and improved "Grade 2" (min 47J av @ -20°C) impact properties.

Ferrocraft 21 is suitable for workshop or 'on-site' repair, maintenance and fabrication welding jobs where the iron powder addition gives improved usability over conventional E4112 rutile type electrodes.

It is the ideal vertical-down fillet welding electrode for thinner steel sections using "Touch Welding" techniques. It produces a controllable fast freezing slag with outstanding slag lift and minimum undercut.

APPROVALS:

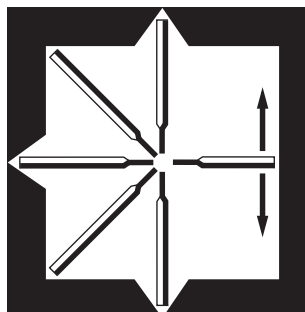
American Bureau of Shipping Grade 2.
 Det Norske Veritas Grade 2.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress 430 MPa
 Tensile Strength 500 MPa
 Elongation 30%
 CVN Impact Values. 90J av @ -20°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.06% Mn: 0.65% Si: 0.30%



All positional - welding#

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Easyweld Handipaks	Part No
2.5	300	50	55-100	5kg	15kg - 3 x 5kg		611242
3.2	380	26	95-140	5kg	15kg - 3 x 5kg		611243
4.0	380	17	140-195	5kg	15kg - 3 x 5kg		611244
5.0	450	9	200-260	5kg	15kg - 3 x 5kg		611245

-5.0mm Ferrocraft 21 is not recommended for out-of-position (ie vertical or overhead) welding applications.