

CIGWELD

AN **ESAB** BRAND

STICK

FERROCRAFT 22

PRODUCT DATA SHEET



RUTILE TYPE HIGH IRON POWDER ELECTRODE

**45
OCV**

**DC
AC**

MILD STEEL AND IRON POWDER ELECTRODES

FERROCRAFT 22

- Rutile Type High Iron Powder Electrode.
- Self Releasing Slag.
- High Productivity Fillet and Butt Welding in All Downhand Positions.
- Packed in Resealable Plastic Tubes.

CLASSIFICATIONS:

ISO AS/NZS 4855:	E 4924 A
AWS/ASME-SFA A5.1:	E7024

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	440 MPa
Tensile Strength	512 MPa
Elongation	25%
CVN Impact Values	60 J av @ 0°C

TYPICAL ALL WELD METAL ANALYSIS:

C:	0.05%
Mn:	0.75%
Si:	0.25%

DESCRIPTION AND APPLICATIONS:

Ferrocrafter 22 is a rutile type high iron powder electrode for the higher productivity fillet and butt welding of mild steel in all downhand (flat and horizontal-vertical) positions.

Slag lift and "side wall" wash at weld toes are superb and welding speeds are approximately double those of conventional electrodes of equal size and length.

Ferrocrafter 22 is recommended for high production welding where large standing fillet welds are required. It is the ideal electrode for heavy structural welding applications such as tanks, frames, girders and beams, ship structures and rolling stock and general fabrication in the workshop or on-site.

PACKAGING & OPERATING DATA:

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

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	APPROX NO. RODS/KG	CURRENT RANGE (AMPS)	PACK SIZE	CARTON	PART NO.
3.2	450	15	130-170	5.8kg	17.4kg - 3 x 5.8kg	611253N
4.0	450	9	180-230	5.3kg	15.9kg - 3 x 5.3kg	611254N
5.0	450	6	250-340	5.2kg	15.6kg - 3 x 5.2kg	611255N

- Ferrocrafter 22 is formulated to operate with AC (min 45 O.C.V.), DC+ or DC- polarity. The preferred polarity for DC fillet welding is DC+.

WELDING POSITIONS:

All downhand welding.

