

# CIGWELD

AN ESAB BRAND

STICK

## SMOOTHCRAFT

### PRODUCT DATA SHEET



**GENERAL PURPOSE,  
RUTILE-ILMENITE TYPE  
ELECTRODE**

**45  
OCV**

**DC  
AC**

**MILD STEEL & IRON POWDER ELECTRODES**

#### SMOOTHCRAFT

- General Purpose, Rutile-Ilmenite Type Electrode.
- Outstanding Operator Appeal!
- Versatile - All Positional Capabilities.
- Smooth Mitre Fillet Welds with Low Spatter.

#### CLASSIFICATIONS:

ISO AS/NZS: 4855	B E4313 A
AWS/ASME-SFA A5.1:	E6013

#### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	430 MPa
Tensile Strength	510 MPa
Elongation	28%
CVN Impact Values	60 J av @ 0°C

#### TYPICAL ALL WELD METAL ANALYSIS:

C:	0.08%
Mn:	0.43%
Si:	0.37%

## DESCRIPTION AND APPLICATIONS:

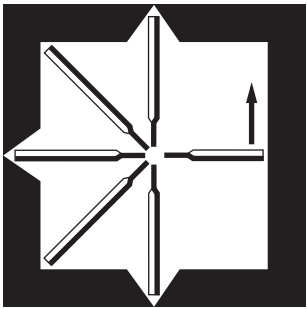
Smoothcraft is an easy-to-use general purpose, rutile-ilmenite electrode suitable for welding in the horizontal-vertical, vertical-up and overhead positions.

Smoothcraft produces smooth professional mitre fillet welds in all positions (except vertical-down) with very low spatter levels, positive re-strike (hot or cold) and self-releasing slag. Smoothcraft can be used with either AC (min. 45 OCV) or DC current.

Applications for Smoothcraft include the general workshop, field and structural welding of mild or galvanised steel components such as pipes, tanks, frames, fences and gates etc. Smoothcraft is particularly recommended for the lap and fillet welding of thin walled galvanised and mild steels where the low spatter levels and excellent edge wetting produce superior results.

## WELDING POSITIONS:

All positional - except vertical down.



## 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)	PACKET	CARTON	PART NO.
2.5	350	53	55-90	5kg	15kg / 3 x 5kg	611042
3.2	350	32	90-135	5kg	15kg / 3 x 5kg	611043
4.0	400	20	135-180	5kg	15kg / 3 x 5kg	611044

