

CIGWELD

AN ESAB BRAND

STICK

WELDCRAFT

PRODUCT DATA SHEET



RUTILE - BASIC TYPE ELECTRODE

45
OCV

DC
AC

MILD STEEL AND IRON POWDER ELECTRODES

WELDCRAFT

- Rutile - Basic Type Electrode.
- Improved Grade 3 Impact Properties.
- Higher Radiographic Quality.
- Versatile "Out-Of-Position" Capabilities.

CLASSIFICATIONS:

ISO AS/NZS: 4855

B E4303 A U

AWS/ASME-SFA A5.1:

E6013

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	420 MPa
Tensile Strength	490 MPa
Elongation	28%
CVN Impact Values	60J av @ -20°C

TYPICAL ALL WELD METAL ANALYSIS:

C:	0.07%
Mn:	0.60%
Si:	0.50%

DESCRIPTION AND APPLICATIONS:

Weldcraft is a popular, rutile - basic type electrode which combines excellent all positional welding capabilities (except vertical-down) with improved radiographic weld deposit soundness and impact toughness.

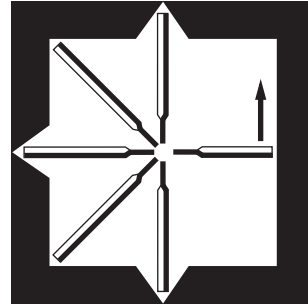
Weldcraft gives better control of the weld pool in vertical-up and overhead welding applications.

As a direct result superior weld profile, edge wetting, penetration and slag lift are consistently achieved. Weld contours in the flat and horizontal-vertical positions are slightly convex and free from undercut.

Weldcraft is suitable for "on site" and workshop welding where better mechanical properties are required and the work cannot be re-positioned to allow welding in the downhand. The electrode is recommended for welding joints subjected to radiographic examination in pressure vessel, ship building, bridge and storage tank fabrications.

WELDING POSITIONS:

All positional - except vertical down.



PACKAGING & OPERATING DATA:

AC (minimum 50 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	300	51	60-95	5kg	15kg / 3 x 5kg	611202
3.2	380	27	95-135	5kg	15kg / 3 x 5kg	611203
4.0	380	17	130-185	5kg	15kg / 3 x 5kg	611204



P/N: 611202



P/N: 611203



P/N: 611204

