

## WELDCRAFT

45  
OCVDC  
AC

- ▲ Rutile - Basic Type Electrode.
- ▲ Higher Radiographic Quality.
- ▲ Improved Grade 2 Impact Properties.
- ▲ Versatile "Out-Of-Position" Capabilities.

## Classifications:

AS/NZS 1553.1: E4113-2.

AWS/ASME-SFA A5.1: E6013.

## 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.

## Packaging and Operating Data:

AC (minimum 50 O.C.V.), DC+ or DC- polarity.

Size mm	Electrode		Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
	Length mm						
2.5	300		54	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

## APPROVALS:

Lloyds Register of Shipping	Grade 3.
American Bureau of Shipping	Grade 3.
Det Norske Veritas	Grade 3

## TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	470 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%
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All positional - except vertical down