


CATEGORY	Oxi-Acetylene welding	
TYPE	Copper-coated unalloyed rod for gas welding.	
APPLICATIONS	Gas welding of unalloyed steels with a minimum tensile strength of 340 MPa. Mainly used for welding plates, pipes and other profiles with low strength required.	
PROPERTIES	Joints are homogenous and soft, the mechanical treatment is very good.	
CLASSIFICATION	AWS EN ISO F-nr FM	A 5.2: R45 20378: 0 1 6 1

SUITABLE FOR	S185, S235JR, St33, St52, St35, St35.8, 1.0035, 1.0561, 1.0308, 1.0305 ASTM: A36, A106 grades A/B, A139 grade A, A216 grades WCA/WCB/WCC, A234 grade WPB
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APPROVALS	CE
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WELDING POSITIONS:	
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TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)			
C	Si	Mn	
0.08	0.1	0.5	

ALL WELD MECHANICAL PROPERTIES						
Heat Treatment	R <sub>p0.2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	RT	Impact Energy (J) ISO-V 0°C	
As Welded /	300	400	20	35	30	

WELDING PARAMETERS / PACKING						
SIZES		WELDING PARAMETERS			PACKING	
D (MM)	LENGTH (MM)	FLAME TYPE		KG / TUBE / CARTON		
1.6	1000	NEUTRAL TO REDUCING		5 / 25		
2.0	1000	NEUTRAL TO REDUCING		5 / 25		
3.0	1000	NEUTRAL TO REDUCING		5 / 25		
4.0	1000	NEUTRAL TO REDUCING		5 / 25		
5.0	1000	NEUTRAL TO REDUCING		5 / 25		
6.0	1000	NEUTRAL TO REDUCING		5 / 25		

REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175	None
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