

CATEGORY	Oxi-Acetylene welding	
TYPE	Copper-coated unalloyed rod for gas welding	
APPLICATIONS	Gas welding of unalloyed steels with a minimum tensile strength of 400 MPa	
PROPERTIES	Joints are homogenous and soft, the mechanical treatment is very good	
CLASSIFICATION	AWS EN ISO F-nr FM	A 5.2: R60 20378: O II 6 1

SUITABLE FOR	S185, S235G2T, S235JR S255GT, S235JO, S275JO S275JR, P235G1TH, P255G1TH, P235GH, P265GH, P285NH ASTM: A36, A106 grades A/B/C, A139 grade A, A210 grades A1/C, A216 grades WCA/WCB/WCC, A234 grade WPB
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APPROVALS	CE
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TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn
0.1	0.15	1.1

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT
As Welded /	320	450	21	50

WELDING PARAMETERS / PACKING

SIZES	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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