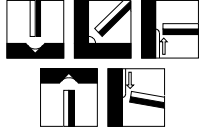


D-60	A VERSATILE HIGH RUTILE - RELATIVELY HIGH CELLULOSE FLUX COATED MILD STEEL ELECTRODE FOR ALL POSITIONAL WELDING INCLUDING VERTICAL DOWN	DATA SHEET NO. 10																																											
SPECIFICATION	AWS A5.1	BS EN ISO 2560-B																																											
CLASSIFICATION	E6012	E4312																																											
PRODUCT DESCRIPTION	The design emphasis of the flux is engineered to produce a fluid but quick freezing slag so facilitating all positional welding including vertical down. The balanced rutile, cellulosic flux containing both alloying and deoxidizing elements is extruded on to a mild steel wire with a blend of silicates that ensures coating strength and stability.																																												
WELDING FEATURES OF THE ELECTRODE	The electrode welds with a stable but forceful arc on both AC and DC but is used to best advantage on DC. The quick freezing slag allows even the larger diameter electrodes to be used vertical down for root runs, in butt and fillet welds. Also useful for tack welds as arc strike and re-strike are excellent and it copes well with rust. Welds are smooth and slag detachability is good.																																												
APPLICATIONS AND MATERIALS TO BE WELDED	All positional welding but used to particular advantage for vertical down fillet welding of the following and related steel specifications : Mild and medium carbon-manganese steels up to 15mm thick with a UTS of 500 N/mm ² max. Typical grades : BS 1449 plate and sheet, BS 4360 grades 43A and 43C, Lloyds A & D ship steel BS 4360 grade 50B Lloyds grades AH and DH, BS 3059 and BS 3601 grade 320-410 API 5L A-B and X42.																																												
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OTHER DATA	Electrodes that have become damp should be re-dried at 110°C for 1 hour.																																												
RELATED PRODUCTS	Please contact our Technical Department for detail.																																												