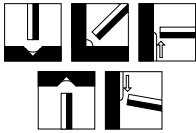


<b>GA-120</b>	<b>RUTILE IRON POWDER ELECTRODE FOR ALL POSITIONAL FILLET WELDING INCLUDING VERTICAL DOWN WELDING</b>				<b>DATA SHEET NO. 4</b>						
							SPECIFICATION	AWS A5.1	BS EN ISO 2560-B		
CLASSIFICATION	E7014	E4914									
PRODUCT DESCRIPTION	<p>A balanced rutile, iron powder, cellulose flux formulation that contains the necessary alloying elements that enables increased metal recovery to be balanced with a quick freezing slag.</p> <p>The flux is extruded onto a mild steel core wire with a blend of silicates that ensures coating strength and stability.</p>										
WELDING FEATURES OF THE ELECTRODE	<p>The arc is stable and smooth both in AC and DC, spatter is negligible. Initial arc strike and re-strike are instant. Slag detachability is excellent and the weld is smooth and evenly rippled. As metal recovery is some 120% with respect to core wire weight, welding efficiency is increased.</p> <p>Fillet welds made in the flat and vertical down position are of a slightly concave appearance.</p>										
APPLICATIONS AND MATERIALS TO BE WELDED	<p>All positional welding including vertical down.</p> <p>Fillet welds of the following materials :</p> <p>Mild and medium carbon-manganese steels up to 15mm thick with a UTS of 500 N/mm<sup>2</sup> max. Typical grades : BS 1449 plate and sheet, BS 4360 grades 43A and 43C, Lloyds A &amp; 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.</p>										
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Cr	Ni	Mo	V	Fe
MIN		-	-	-	-	-	-	-	-	-	
MAX		0.15	1.25	0.9	0.035	0.035	0.2	0.3	0.3	0.08	
TYPICAL		0.06	0.9	0.3	0.02	0.02	0.03	0.03	0.2	0.02	Bal.
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY	UNITS	MINIMUM	TYPICAL	OTHERS						
	Tensile strength	N/mm <sup>2</sup>	490	540							
	0.2% Proof stress	N/mm <sup>2</sup>	400	450							
	Elongation on 4d	%	17	28							
	Reduction of Area (RA)	%	-	70							
	Impact energy 0°C	J	-	30							
WELDING AMPERAGE AC or DC	Ø (mm)	3.2	4.0	5.0							
	MIN	110	150	190							
	MAX	160	200	260							
OTHER DATA	Electrodes that have become damp should be re-dried at 120°C for 1 hour.										
RELATED PRODUCTS	Please contact our Technical Department for detail.										