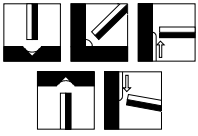


<b>RD-48</b>	<b>BASIC COATED LOW HYDROGEN ELECTRODE FOR VERTICAL DOWN WELDING</b>			<b>DATA SHEET NO.</b>						
				<b>30</b>						
SPECIFICATION	AWS A5.1	BS EN ISO 2560-B	JIS Z 3212							
CLASSIFICATION	E7048	E4948	D5016							
PRODUCT DESCRIPTION	<p>The design emphasis of the chemically basic flux has been engineered to ensure a very fast freezing slag that imparts to the electrode the rather unique ability to be used for vertical down welding.</p> <p>The flux coating also contains the appropriate alloying and deoxidation elements to ensure the weld metal properties demanded by the specification are fully met. The blend of silicates used ensure both the strength of the flux coating and resistance to subsequent moisture re-absorption.</p>									
WELDING FEATURES OF THE ELECTRODE	<p>As the electrode is designed for vertical down welding, particularly fillet welds with awkward joint access.</p> <p>The electrode can be used AC or DCEP with the electrode at an angle of 45° to 80° from the vertical with a short arc technique with no weaving. Starts and re-starts should be made with a back step technique.</p> <p>Fillet welds have a very slight convex profile and the weld metal appearance is smooth and bright.</p>									
APPLICATIONS AND MATERIALS TO BE WELDED	<p>Medium and high tensile carbon-manganese steels with UTS of up to 510N/mm<sup>2</sup> max. Typical grades: BS1449 plate and sheet BS4360 grades 43A and 43C Lloyds A &amp; D ship steel BS4360 grade 50B, Lloyds grades AH and DH BS3059 and BS3601 grade 320-410 API 5L A-B and X42, BS4360-50B-50C-50D, BS1501-151 430-490, BS3602-410-460.</p> <p>Such steels are used in ship construction, bridge building and pressure vessel work as well as general construction work.</p>									
WELD METAL ANALYSIS COMPOSITION % BY Wt.	C	Mn	Si	S	P	Cr	Ni	Mo	V	Fe
	MIN	-	-	-	-	-	-	-	-	
	MAX	0.1	1.6	0.9	0.035	0.035	0.2	0.3	0.3	0.08
	TYPICAL	0.08	1.0	0.65	0.02	0.02	0.1	0.1	0.01	0.01 Bal.
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY		UNITS	MINIMUM	TYPICAL	OTHERS				
	Tensile strength		N/mm <sup>2</sup>	490	600					
	0.2% Proof stress		N/mm <sup>2</sup>	400	520					
	Elongation on 4d		%	22	28					
	Reduction of Area (RA)		%	-	70					
Impact energy -30°C		J	27	60						
WELDING AMPERAGE AC or DC+	Ø (mm)	3.2	4.0	5.0						
	MIN	110	140	220						
	MAX	150	210	270						
OTHER DATA	Electrodes that have become damp should be re-dried at 150°C for 1 hour.									
RELATED PRODUCTS	Please contact our Technical Department for detail.									