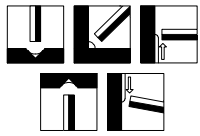


RD-360U	BASIC LOW HYDROGEN ELECTRODE FOR VERTICAL UP ROOT RUNS ACCESSIBLE FROM ONE SIDE ONLY				DATA SHEET NO. 20						
SPECIFICATION	AWS A5.1	BS EN ISO 2560-B	JIS Z 3212								
CLASSIFICATION	E7016	E4916	D5016								
PRODUCT DESCRIPTION	<p>The design emphasis of this chemically basic flux is engineered towards allowing controlled penetration root runs in the vertical up position when joint access is from one side only.</p> <p style="text-align: center;">UNCONTROLLED</p> <p>State of the art deoxidation and micro alloying techniques ensure the mechanical properties demanded by the specification are fully met and the silicates used to bind the flux ensure very low hydrogen levels and excellent coating strength.</p>										
WELDING FEATURES OF THE ELECTRODE	<p>The chemical nature of the flux allows very low amperages to be used on AC and DC+ and even DC- for controlled penetration root runs. The arc is smooth and stable and the black viscous slag readily detachable, the resultant weld seams are bright and smooth. The electrode is designed solely for one sided vertical up welding and overhead welding and the very design features that make this possible will limit its use on other joint configuration.</p>										
APPLICATIONS AND MATERIALS TO BE WELDED	<p>Medium and high tensile carbon-manganese steels with UTS of up to 510N/mm² 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, BS 4360-50B-50C-50D, BS 1501-151 430-490, BS 3602-410-460. 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		0.15	1.6	0.75	0.035	0.035	0.2	0.3	0.3	0.08	
TYPICAL		0.1	1.0	0.5	0.01	0.02	0.15	0.05	0.01	0.01	Bal.
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY	UNITS	MINIMUM	TYPICAL	OTHERS						
	Tensile strength	N/mm ²	490	650							
	0.2% Proof stress	N/mm ²	400	550							
	Elongation on 4d	%	22	26							
	Reduction of Area (RA)	%	-	70							
	Impact energy -30°C	J	27	60							
WELDING AMPERAGE AC or DC+	Ø (mm)	2.6	3.2	4.0	5.0						
MIN		50	75	130	170						
MAX		85	125	170	220						
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.										
APPROVED BY	LR – Grade 3Y H5										