	TECHNICAL DESCRIPTION	FT-DT.42.08
	EUROTROD BD 22	PAGE. 15/15

CERTIFIED COMPANY:



CLASSIFICATION:

AWS A5.1: E 7016
EN ISO 2560-A-E 38 2 B 1 2 H10

DESCRIPTION:

Double coating basic type electrode, owing a stable arc, is ideal for positional welding and root pass. Suitable for carbon steels and some low alloy steels.

SUITABLE FOR:

St 33 to St 52.3	St 35.8 to 17 Mn 4	StE 255 to StE 355	GS-38 to GS-52
H I, H II, 17 Mn 4	StE 210.7 to StE 360.7	WStE 255 to WStE 355	
St 37.4 to St 52.4	StE 210.7 TM to StE 360.7 TM	A, B, D, E	

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:

Chemical Analysis (%):

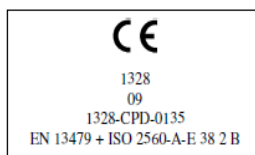
C	Si	Mn	P	S			
0,08	0,50	1,10	< 0,02	< 0,02			

Mechanical Properties:

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 5d (%)	CHARPY V (J)	
			+20°C	-30°C
>450	>550	>25	>100	>40

PRODUCT INFORMATION:

WELDING PARAMETERS				VACUUM PACKING	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces /Packet (Un)	Weight /Packet (kg)
2,0	350	55 – 65	AC/DC	180	2,3
2,5	350	60 – 90	AC/DC	95	1,9
3,2	350	95 – 150	AC/DC	55	1,8
3,2	450	95 – 150	AC/DC	55	2,3
4,0	350	140 – 190	AC/DC	35	1,8
4,0	450	140 – 190	AC/DC	35	2,3
5,0	450	180 – 250	AC/DC	30	3,0
6,0	450	260 – 330	AC/DC	20	3,3



WELDING POSITIONS:

