

Phoenix K 50 R

Stick electrode, unalloyed, basic

Classifications								
EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M					
E 42 3 B 3 2	E 4916 AU	E7016	E4916					

Characteristics and typical fields of application

Very good welding characteristics for pipe root welding; fine droplet transfer; very pure weld metal; 110 % weld metal recovery; cold toughness at temperatures as low as –30 °C (–22 °F). Good weldability in out of position welding. Specially intended for pipeline constructions; optimal for on site work; for pipe steels, boiler plates, pipeline steels and fine grained structural steels.

Base materials

Boiler steels P235GH, P265GH, P295GH; fine grained structural steel up to S355N

Typical analysis of all-weld metal (wt%)												
	С		Si			N	Mn					
wt-%	0.06		0.55			0	0.95					
Mechanical properties of all-weld metal												
Heat- treatment	Yield strength R _{p0.2}	Tensile R _m	e strength	Elongation A (L ₀ =5d ₀)			Impact work ISO-V KV J		k J			
	MPa	MPa		%			+20 °C		−30 °C			
aw	420	510		22			120		47			
sr	360	490		26			120		47			
Operating data												
	Polarity: DC(+)/ AC 2	Redr 250 – 35 (482 –	ying: 0 °C / 2 h 662 °F)	Ø (mm) 2.5 2.5 3.2 4.0	L	. mm 250 350 350 350	((() () () () () () () () ()	Amps A 50 – 110 50 – 110 30 – 130 20 – 180			

Approvals

TÜV (01587), DB (10.132.18) ABS, GL, LR, DNV, CE