Phoenix SH Blau

Stick electrode, unalloyed, rutile, cellulosic

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 42 0 RR 1 2	E 4313 A	E6013	E4313

Characteristics and typical fields of application

Easy striking and restriking; preferred for tack-welding; good gap-bridging capability. For use in general structural engineering and steel, tank and apparatus construction; all purpose.

Also weldable in the vertical down position in diameters up to 3.2 mm. For universal use.

Base materials

S235JRG2 - S355J2; boiler steels P235GH, P265GH; ASTM A36 u. A53 Gr. alle; A106 Gr. A, B, C; A135 Gr. A, B; A283 Gr. A, B, C, D; A366; A285 Gr. A, B, C; A500 Gr. A, B, C; A570 Gr. 30, 33, 36, 40, 45; A607 Gr. 45; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A935 Gr. 45; A936 Gr. 50; API 5 L Gr. B, X42-X52

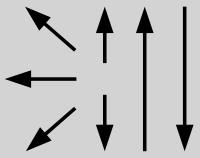
Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn
wt-%	0.08	0.40	0.60

Mechanical properties of all-weld metal

Heat-treatment	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
aw	420	510	22	55

Operating data



Polarity:	ø (mm)	L mm	Amps A
DC (–) / AC	2.0	250	45 – 70
	2.5	350	60 – 95
	3.2	350	90 – 135
	4.0	350	140 – 180
	5.0	450	190 – 230

Approvals

TÜV (00342), DB (10.132.60) GL, LR, CE