Phoenix SH Gelb R

Stick electrode, unalloyed, rutile basic

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 38 2 RB 1 2	E 4303 AU	E6013	E4313

Characteristics and typical fields of application

Excellent vertical up welding characteristics; easy handling in out of position work; particularly suitable for fabricating radiographically sound circumferential pipe welds; good porosity-free root weld fusion, also in tight air gaps.

Useable in pipeline, boiler and tank construction, structural steel work and shipbuilding.

Base materials

S235JRG2 - S355J2; shipbuilding steels appr.-grade 3;

Boiler steels P235GH, P265GH, P295GH;

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

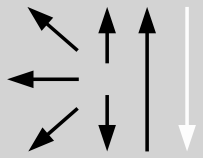
Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn
wt-%	0.08	0.20	0.55

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	380	460	22	75

Operating data



Polarity:	ø (mm)	L mm	Amps A
DC (–) / AC	2.0	250	30 – 75
	2.5	250	40 – 90
	2.5	350	40 – 90
	3.2	350	90 – 130
	4.0	350	140 – 190
	4.0	450	140 – 190
	5.0	450	190 – 250

Approvals

TÜV (01591), DB (10.132.20), ABS, BV, GL, LR, DNV, CE