to its higher current characteristics, welding is much
unalloyed, micro alloyed and low alloy steels, also
An
quality, notch tough weld metal. Easy restrike. Can
Grade 3, 3YH15.
are flat in profile and insensitive to cracking. LRS
bridges gaps with remarkable ease. Welding is very
is very suited for welds in narrow Vee joints. The
hand position on heavy plate and joints in restraint.
coating gives high efficiency combined with excellent
excellent X-ray and mechanical results. Ideal for
because with one current setting welds can be done
gaps have to be bridged. It is perfect for site work
This medium-heavy coated rutile electrode produces
with reasonably smooth deposits. A very useful
machines and has easy starting and restarting
This is a conventional type of electrode which welds
E4916 N5P H10
approved. These electrodes must be kept very dry.
steel, ie forklift prongs, axles, shafts, etc. ABS
Available on special order
This is a conventional type of electrode which welds
E5515-2C1ML H5
Problem Steels
This deposits a weld metal of an austenite/ferritic
structure which is highly resistant to cracking. Hence
As welds on stainless steels cause stress cracks, it
is also suited for welding to weld crevice resistant steels
welding, correct pre-heat and interpass temperature
For welding steels alloyed with 2.25% Cr/1.0% Mo
can be used to weld 12CrMoV 9-13 and 10CrMo9.
PH RM318LC is an all position, rutile coated
ES309LMo-17
The weld metal is stabilised by Mo and 316L.
PH 712 is a high carbonchromium type for impact
and severe abrasion and has good resistance to scaling
in high temperatures. It can be used for
PH RS310Mo is an all position, rutile coated
EGN 2517-14
E4916 N5P H10
WELDING ELECTRODES
SPECIAL APPLICATIONS
Molybdenum bearing 316 and 316L steels. The weld
deposit is highly resistant to corrosion by strong
suitable for welding AISI types 318 and 316. The
PHRM318LC deposits a stabilised weld metal
E4916 N5P H10
PHKV5 7015-B2L 5215-
PH KV5 is very good in all positions. The weld metal
improved strength and toughness are desired.
For welding steels alloyed with 2.25% Cr/1.0% Mo
and is recommended for welding (0.5%) Cr/0.5% Mo
steels. When used with very low hydrogen welding,
correct pre-heat and interpass temperature control must be used. PH RS310 exhibits excellent
welding properties on most stainless steels. Welded
with a short arc.
PH RS310Mo1CSgenerate a buffer layer of RSP or 56S or 77 is recommended. Deposit is malleable and
forgeable when hot. Typical undiluted hardness 59Rc. Base metal is hardenable or high alloy,
Typical undiluted hardness 62Rc.
Typical undiluted hardness 62Rc.
Deposit hardness HRC 40 to 80. Highest abrasion resistance is achieved at HRC 70.
Deposit hardness HRC 25 to 65.
If both electrodes have the same marking, it is possible
for welding steels alloyed with 2.25% Cr/1.0% Mo.
PH KV3 is very good in all positions. The weld metal
improved strength and toughness are desired.
For welding steels alloyed with 2.25% Cr/1.0% Mo.
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