



Dual-Coated

Dual coated Low Hydrogen electrode for MMA welding of Mild Steel

Basic coated Low hydrogen electrode for the joining of mild and medium Carbon/Manganese steels. The dual coating enhances the operability to give the same ease of use, as that of general-purpose electrode with the properties of a basic low hydrogen electrode with exceptional re striking.

International Standards

ISO 2560 - A -:2005	AWS A5.1 - 04
E 38 2 B 12 H10	E7016 type

Typical All-weld Metal Analysis (wt%)

C	Si	Mn	S	P
0.09	0.7	0.9	<0.025	<0.025

Typical All-weld Metal Mechanical Properties

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation %	Impact Strength -20°C
>380	470-600	>20	>100J

Welding Positions

All positions except vertical down

Materials

ASTM A283 Grade B C D, A355 A570 Grade 30,33,40,50 A709 Grade 50 API 5LX 42,46,52, and 60
--

Packaging

Size mm	2.5 x 350	3.2 x 350	4.0 x 450
Pieces/Packet	250	165	105
Pieces/Carton	1000	660	420
Kg/Package	5.0	5.0	5.0
Packets/Carton	4	4	4
Kg/Carton	20.0	20.0	20.0

Operating Requirements

DC+/-AC(70 ocv min)	60-90A	90-130A	120-180A
----------------------------	---------------	----------------	-----------------

Additional Information

CE Certified	Constructional products directive (CPD)
Certification	BS EN 10204:2004 Type 2.2
Material safety data sheet	MSDS 04
Re-dry	Two hours @300°C to maintain Low Hydrogen levels
Related Nexus Products	MIG Nexus SG2/SG3 TIG A15/A18