THIS PRODUCT HAS THE FOLLOWING OPTIONS:

Welding Electrodes 3.2mm
Welding Electrodes 4.0mm

OVERVIEW
The Barracuda general-purpose mild steel electrodes (nearest equivalent E6013) comprises of a silicone free CMn core wire with a thick rutile alumina silicate flux coating.
FEATURES

SPECIFICATION

WELD METAL PROPERTIES
Mechanical Analysis Tensile Strength (Nmm.sq.) - Dry 540. Wet 564.
Elongation on 4d - Dry 26%. Wet 10%.
Reduction of Area - Dry 70%. Wet 47%
Charpy Impact Energy @ (0 deg. C) - Dry 62J. Wet 34J.
Chemical Analysis - Deposited Weld Metal Analysis Carbon (C) - Typical (dry) 0.05%
Manganese (Mn) - Typical (dry) 0.5%
Silicon (S) - Typical (dry) 0.45%
Sulphur (S) - Typical (dry) 0.025%
Phosphorous (P) - Typical (dry) 0.025%

WELDING PARAMETERS
Electrode Dia - 3.2mm 4.0mm &amp 5.0mm
Electrical Characteristics Current Type - DC only
Polarity - DCSP (-Ve) or DCRP (+Ve)
Amps - 3.2mm 90-145 (165 max). 4.0mm 130-220 (240 max). 5.0mm 240-290 (310 max).
Volts - (OCV) 80 (max)

RECOMMENDED WELDING TECHNIQUES
The welding techniques we recommend for underwater wet welding are touch technique of which there are essentially three variations: Drag Oscillation Step-back We recommend that all underwater wet welding should be carried out using DCSP. However the electrode will also perform satisfactorily on DCRP should this be necessary. In addition a circuit breaker should be fitted into the welding circuit to allow for safe isolation. This may be either dual pole or single pole. The use of double insulated welding cables and a suitably insulated electrode holder is also required. The use of the Piranha weld control unit is recommended as it also provides essential welding parameter information and offers fault finding capabilities for the welding plant and welding circuit.

ORDER THIS PRODUCT
To order this product or to request a price contract our UK sales team on
+44 (0)1772 687775
Alternatively you can place a quote request through our website
http://www.smp-ltd.co.uk/ or send an email to sales@smp-ltd.co.uk