

SMAW**For Mild Steel****POWERWELD S-12**

CLASSIFICATION : AWS A5.1 E6013

JIS Z3211 D4313

WELDING POSITIONS :



- Rutile Type Electrode
- All Positional (Including Vertical Down) Capabilities
- Smooth, Stable Performance On All Welding Machines

Approval	
Lloyds Register Of Shipping	Grade 2
American Bureau Of Shipping	Grade 2

DESCRIPTION AND APPLICATIONS

POWERWELD S-12 is a high rutile type electrode designed for manual arc welding in all positions. Smooth mitre fillet welding can be obtained with "Touch" welding or a short arc welding technique in the flat and horizontal / vertical fillet positions.

The electrodes outstanding and distinguish features are :

- Smooth and soft arc
- Slag release by itself
- Low spatter level
- Low fume level
- Electrodes individually branded
- Easy restriking even at low voltage machine
- Suitable for A.C. or D.C. welding current supply

Especially recommended for welding of general structural steel fabrication such as gates, fences, trailer and steel furniture etc. Particularly suitable for downhand fillet and butt welding. For welding thin plate, small size electrode is recommended.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)				
C	Mn	Si	P	S
0.07	0.45	0.41	0.018	0.010

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES•			
YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
430 N/mm ²	490 N/mm ²	26%	82J @ 0°C

• in "as welded" condition.

OPERATIONAL AND PACKAGING DATA				
ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE • (amps)	PACKAGING (kg)	
			PKT	CTN
2.0	300	40 - 60	5	20
2.6	300	50 - 90	5	20
3.2	350	90 - 130	5	20
4.0	400	120 - 170	5	20
5.0	400	170 - 230	5	20

• Recommended for DC+ or AC (minimum 45 OCV) operation