Ferrocraft 22



Typical All Weld Metal Analysis:

- Rutile Type High Iron Powder Electrode
- · High Productivity Fillet and Butt Welding in All Downhand Positions
- · Self Releasing Slag
- Recommended for high production welding where large standing fillet welds are required
- Ideal electrode for heavy structural welding tanks, frames, girders, beams, ship structures, rolling stock and general fabrication in the workshop or "on-site"

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AS/NZS 4855: (new) AS/NZS 1553.1: (old) AWS/ASME-SFA A5.1:

E4924 A
4824-0
7024

Typical All Weld Metal Mechanical Properties:

Properties:		0:0.00% NIII:0.75% SI:0.25%		
Yield Stress	440 MPa			
Tensile Strength	512 MPa	Approvals:		
Elongation	25%	Lloyds Register of Shipping	Grade 2Y	
CVN Impact Values	60J av @ 0°C.	American Bureau of Shipping	Grade 2	
•		Det Norske Veritas	Grade 2	

Packaging and Operating Data:

Elect Size mm	rode Lenath mm	Approx No. Rods/ka	Current Range (amps)	Packet	Carton	Part No	
			· 3· (· 1··)				
2.5	350	34	85 – 120	5kg	15kg – 3 x 5kg	611252	
3.2	380	18	90 – 135	5kg	15kg – 3 x 5kg	611253	
4.0	450	11	185 – 235	5kg	15kg – 3 x 5kg	611254	
		-					
5.0	450	1	260 - 320	5kg	15kg – 3 x 5kg	611255	
	Elect Size mm 2.5 3.2 4.0 5.0	Electrode Size mm Length mm 2.5 350 3.2 380 4.0 450 5.0 450	Electrode Size mm Approx No. Length mm Approx No. Rods/kg 2.5 350 34 3.2 380 18 4.0 450 11 5.0 450 7	Electrode Size mm Approx No. Length mm Current Rods/kg Current Range (amps) 2.5 350 34 85 – 120 3.2 380 18 90 – 135 4.0 450 11 185 – 235 5.0 450 7 260 – 320	Electrode Size mm Approx No. Length mm Current Rods/kg Packet 2.5 350 34 85 - 120 5kg 3.2 380 18 90 - 135 5kg 4.0 450 11 185 - 235 5kg 5.0 450 7 260 - 320 5kg	Electrode Size mm Approx No. Length mm Current Rods/kg Packet Range (amps) Carton 2.5 350 34 85 – 120 5kg 15kg – 3 x 5kg 3.2 380 18 90 – 135 5kg 15kg – 3 x 5kg 4.0 450 11 185 – 235 5kg 15kg – 3 x 5kg 5.0 450 7 260 – 320 5kg 15kg – 3 x 5kg	

Ferrocraft 22 is formulated to operate with AC (miniumum 45 OCV) DC+ or DC- polarity. The preferred polarity for DC fillet welding is DC+.

Pipearc 6010P

- User Friendly Pipe Welding Electrode
- Lower Spatter Levels and Easy Slag Removal
- Excellent Reverse Bead Formation on Butts
- Versatile "Out-of-Position" Capabilities
- Batch Numbered for On-the-Job Traceability
- Used to weld out (root, fill and cap) steel pipes such as API 5L, 5LX grades X42 to X52
 Welding of "V" butt (groove weld) joints in higher strength steels, including 5LX
- grades X60, X65 and X70. Recommended for root pass welding only.

Classifications:

AS/NZS 4855: (new) AS/NZS 1553.1: (old) AWS/ASME-SFA A5.1: B E4310 A E4110-2 E6010

Typical All Weld Metal Mechanical

400 MPa

510 MPa

65J av @ -20°C

40J av @ -30°C

30%

Properties:
Yield Stress
Tensile Strength
Elongation
CVN Impact Values

Typical All Weld Metal Analysis: C: 0.11% Mn: 0.46% Si: 0.15%

S: 0.011% MIN: 0.46% SI: 0.15% S: 0.011% P: 0.012%

Approvals:

Lloyds Register of Shipping	Grade
American Bureau of Shipping	Grade
Det Norske Veritas	Grade

The results quoted in this data sheet are obtained from the listed Shipping Societies (ABS, DNV, LRS) Conformance Tests and Procedures. Actual weld metal mechanical properties achieved with PipeArc 6010P are influenced by many factors including, base metal analysis, welding parameters / heat input used, number of weld passes and run placement etc. On the job mechanical tests may produce different results. Please consult your CIGWELD Area Manager or Customer Service for welding procedure recommendations.

Packaging and Operating Data:

	Elect Size mm	trode Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
	2.5	300	66	45 – 85	5kg	15kg – 3 x 5kg	615602
	3.2	350	39	90 – 135	5kg	15kg – 3 x 5kg	615603
	4.0	350	25	135 – 180	5kg	15kg – 3 x 5kg	615604
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DC+ (Direct Current Electrode Positive) polarity

Ferrocraft 11

- Cellulose Pipe Welding Electrode
- All Positional, AC / DC Capabilities
- High Penetration, Root Pass Applications
- WHITE flux colour for easy ID
- Recommended for root pass welding where the "stovepipe" or "flick" techniques can be used to achieve full root penetration
 The root, hot fill and capping pass welding of pipelines, pressure vessels,
- storage tanks, workshop and field construction

Classifications:

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AS/NZS 4855: (new) AS/NZS 1553.1: (old) AWS/ASME-SFA A5.1:

Professional

B E4311 A E4111-2 E6011

Typical All Weld Metal Mechanical

 Properties:

 Yield Stress
 415 MPa

 Tensile Strength
 500 MPa

 Elongation
 28%

 CVN Impact Values
 90J av @ -20°C

Typical All Weld Metal Analysis: C: 0.12% Mn: 0.47% Si: 0.10% S: 0.007% P: 0.011%

DC AC

65

OCV

Approvals:

Lloyds Register of Shipping	Grade 3, 3Y
American Bureau of Shipping	Grade 3
Det Norske Veritas	Grade 3

Packaging and Operating Data:

Electrode		Approx No. Current	Packet	Carton	Part No	
Size mm	Length mm	Rods/kg	Range (amps)			
2.5	300	62	65 - 85	5kg	15kg – 3 x 5kg	611132
3.2	380	33	95 – 125	5kg	15kg – 3 x 5kg	611133
4.0	380	22	130 – 160	5kg	15kg – 3 x 5kg	611134
	Elect Size mm 2.5 3.2 4.0	Size mm Length mm 2.5 300 380 3.2 380 380	Electrode Approx No. Size mm Length mm Rods/kg 2.5 300 62 3.2 380 33 4.0 380 22	Electrode Approx No. Current Size mm Length mm Rods/kg Range (amps) 2.5 300 62 65 - 85 3.2 380 33 95 - 125 4.0 380 22 130 - 160	Electrode Size mm Approx No. Rods/kg Current Range (amps) Packet 2.5 300 62 65 - 85 5kg 3.2 380 33 95 - 125 5kg 4.0 380 22 130 - 160 5kg	Electrode Size mm Approx No. Range (amps) Current Range (amps) Packet Carton 2.5 300 62 65 – 85 5kg 15kg – 3 x 5kg 3.2 380 33 95 – 125 5kg 15kg – 3 x 5kg 4.0 380 22 130 – 160 5kg 15kg – 3 x 5kg

AC (miniumum 65 OCV) DC+ or DC- polarity.



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