

Classification Of High Strength Electrodes As Per TS EN 757-2002

E 69 6 Mn2Ni Mo B 2 3 H5											
Product		Yield Strength, Tensile Strength & Elongation			Chemical Composition %			Electrode Covering			
G	Wire Electrodes	Symbol	ReL (N/mm ²)	Rm (N/mm ²)	A (%)	Mn	Ni	Cr	Mo	A	Acide Covering
O	Oxy-Acetylene	55	550	610-780	18	1.4-2.0	-	-	0.3-0.6	C	Cellulosic Covering
E	Electric Arc Welding	62	620	690-890	18	Mn1Ni1	0.6	-	-	R	Rutile Covering
S	Submerged Arc Welding Wires	69	690	760-960	17	1NiMo	1.4	0.6-1.20	0.3-0.6	RR	Thick Rutile Covering
T	Flux-Cored Wires	79	790	880-1080	16	1.5 NiMo	1.4	1.2-1.8	-	RC	Rutile-Cellulosic Covering
W	TIG Rods	89	890	980-1180	15	2.0 NiMo	1.4	1.8-2.6	-	RA	Rutile-Acid Covering
F	Submerged Arc Welding Fluxes									RB	Rutile-Basic Covering
Symbols for Impact Properties Of All-Weld Metal (Min. 47J)										B	Basic Covering
Symbol	Temperature °C										
Z	No Requirements										
A	(+20)										
0	0										
2	-20										
3	-30										
4	-40										
5	-50										
6	-60										
7	-70										
8	-80										
Symbols For Weld Metal Recovery And Type Of Current (%)											
1	105	≈/=									
2	105	=									
3	> 105 ≤ 125	≈/=									
4	> 105 ≤ 125	=									
5	> 125 ≤ 160	≈/=									
6	> 125 ≤ 160	=									
7	> 160	≈/=									
8	> 160	=									
Symbols For Hydrogen Content Of All-Weld Metal											
Symbol	MI / 100g										
H 5	5										
H 10	10										
Symbols for Welding Positions											
1	PA; PB; PC; PD; PE; PF; PG										
2	PA; PB; PC; PD; PE; PF;										
3	PA; PB; PC										
4	PA; PB										
5	PA; PB; PG										

Email : sales@ferrsol.com | Web : www.ferrsol.com