



# WELDEX™

# 50

**LOW HYDROGEN**

WX50E7016E4816



## **A TWIN FLUX COATED ELECTRODE PROVIDING AN EXTREMELY STABLE ARC IN ALL POSITIONS**

### Technical Information

An outstanding electrode for pipe root passes and structural applications where high strength welds are required. The deposit provides excellent mechanical properties, recommended for un-alloyed, micro-alloyed and low-alloyed steels of the medium tensile class. This electrode provides a superb result where a high degree of penetration is critical, particularly demanded by the Oil and Gas Industry for offshore and onshore process piping.

### Unique Features

- Outstanding strike and restrike characteristics
- Exceptional arc stability
- Excellent low temperature welding
- Exceptional mechanical and X-Ray properties
- Positional welding excellent



### Application Procedures

For best results, hold a close arc. Avoid wide weaving and maintain a molten pool at all times during welding. Avoid a cold start by striking the arc slightly ahead of the intended weld. For maximum mechanical and X-Ray properties. It is recommended to use dry rods only. Re-drying temperature 300 degrees Centigrade/1 hour.

### Technical Properties

		<u>SIZES</u>	<u>RECOMMENDED</u>
		<u>AVAILABLE</u>	<u>AMPERAGES</u>
Tensile Strength	- 550mpa (80,000 psi)	2.6mm	60-90
Yield Strength	- 460mpa (67,000 psi)	3.2mm	90-140
Elongation of	- (5 x D) 31%	4.0mm	140-190
Reduction of area	- 70%	5.0mm	190-250