



WELDEX™

70

LOW HYDROGEN - IRON POWDER WX70E7018E4818



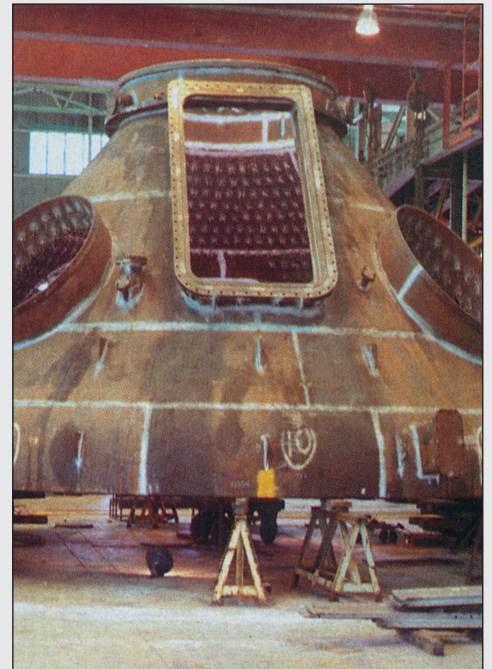
WELDS A WIDE RANGE OF UN-ALLOYED MICRO-ALLOYED STEELS WITH EXCELLENT MECHANICAL AND X-RAY PROPERTIES

Technical Information

Developed as a hydrogen-controlled electrode containing iron powder in the flux coating. This greatly increases the efficiency of the electrode by increasing the deposition rate to approximately 120% recovery. The electrode gives exceptional results on AC& DC current in all positions. The deposit is smooth and finely rippled with excellent wash to weld sides, resulting in excellent penetration without undercut.

Unique Features

- Controlled fast deposits
- Smooth rippled finish
- Exceptional penetration and strength
- All positions AC/DC
- Excellent X-Ray characteristics



Application Procedures

Being an iron powder type low-hydrogen electrode, current is slightly higher producing a faster weld deposit than normal. A shorter arc is required to give maximum control resulting in a high penetration smooth weld, which complies with X-Ray standards. It is recommended to use dry rods only. Re-drying temperature 300 degrees Centigrade/1 hour.

Technical Properties

		SIZES AVAILABLE	RECOMMENDED AMPERAGES
Tensile Strength	- 530mpa (77,000 psi)	2.6mm	60-90
Yield Strength	- 440mpa (64,000 psi)	3.2mm	90-130
Elongation of	- (5 x D) 28%	4.0mm	120-180
Reduction of area	- 70%	5.0mm	190-230