



PRODUCT INFORMATION

SIFTRODE SPEZIAL

AWS A5.1 E 7016
EN ISO 2560 E 42 2 B(R) 12 H10

DESCRIPTION

Double coated rutile-basic universal electrode. Ideal for use in pipelines and steel construction. For joint penetrations and welding in difficult positions. Excellent welding properties, smooth and pure joints. 100% second ignition. Double coating results in stable, concentrated and direct arc.

WELDING POSITIONS



Welding current: AC, DC(-) joint penetration, DC(=) filling,
Positions PA, PB,PC,PD,PE,PF

TYPICAL WELD METAL COMPOSITION

C	0.06 %
Mn	0.75 %
Si	0.55 %

TYPICAL MECHANICAL PROPERTIES

0.2% Yield Strength	≥ 420 N/mm2
Ult Tensile Strength	≥ 500-640 N/mm2
Elongation	~ 20%
Impact Values ISO-V	-30° ≥47J

MATERIAL TO BE WELDED

Construction steels: S235-S355
Boiler plates: P235GH – P355GH
Pipe steels: P235-P355N
Shipbuilding plates: A,B,D

AVAILABLE FORMATS

ELECTRODE RODS (MMA / SMAW)			
Dia	2.5kg Pkt	5.0kg Pkt	Approx Pcs/KG
2.5mm	RE852525		50
3.2mm	RE853225		30
4.0mm	RE854025		15

CURRENT RANGE	
Dia (mm)	Amps
2.5	60-90
3.2	90-140
4.0	140-190

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email service@wholeweld.co.uk



Doc Ref : SIF/PI/RE601602