



P 39

SMAW - (Stick) - MMA
Un-alloyed

Date: 2014-01-29
Revision: 21

Description:

P 39 is a rutile-basic coated electrode specially designed for welding the root and first pass in mild steel pipe with wall thickness 4-10 mm. It has a forceful, penetrating arc and mixed-mode droplet transfer. It is an AC/DC electrode, with (-) polarity preferred and is suitable for all positions except vertical down. For both root and first pass the electrode should be weaved, with a slight dwell at the joint edges.

Welding positions:

1 2 3 4 T 6

Coating type:

Rutile

Welding current:

DC-, AC OCV> 65 V

Metal recovery:

95%

Redrying temperature:

90 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,10	0,6				
Typical	0,10	0,20	0,8	0,020	0,020		
Max	0,12	0,50	1,1	0,030	0,020	0,2	0,3

	Mo	Cu	V
Min			
Typical			
Max	0,2	0,3	0,05

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥ 380 MPa	390 MPa
Tensile Strength, Rm:	490-600 MPa	520 MPa
Elongation, A5	≥22%	25%
Impact energy, CV:	-20 °C • 47 J	0 °C • 65 J

Classification:

EN ISO 2560-A E 38 2 RB 12
AWS A5.1 E 6013

Approvals:

CE
DB Kennblatt Nr. 10.042.02
TÜV
GL 3Y

Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,5	350	71392500	90-110	25	0,60	87	0,8	46
3,2	350	71393200	130-155	24	0,6	49	1,1	59
4,0	350	71394000	160-200	24	65	30	1,5	71