



P 43

SMAW - (Stick) - MMA
Un-alloyed

Date: 2013-07-03
Revision: 19

Description:

P 43 is a medium-coated rutile electrode intended for welding light to medium sections in mild steel. The electrode operates with a very smooth arc and is suitable for all positions except vertical down. It is easy to strike and re-strike and produces a self-detaching slag leaving a finely rippled bead appearance. With its excellent bead surface and smooth transition with the base material P 43 is ideal for butt and fillet welding of sheet metal work.

Welding positions:



Coating type:

Rutile

Welding current:

DC+/-, AC OCV ≥ 50 V
For root passes: DC-

Metal recovery:

95%

Redrying temperature:

90 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,30	0,30				
Typical	0,07	0,4	0,5	0,015	0,015		
Max	0,11	0,60	0,75	0,030	0,020	0,1	0,2

	Mo	Cu	V	Nb
Min				
Typical				
Max	0,1	0,2	0,05	0,05

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥ 420 MPa	480 MPa
Tensile Strength, Rm:	510-560 MPa	550 MPa
Elongation, A5	$\geq 22\%$	24%
Impact energy, CV:	0 °C • ≥ 47 J	0 °C • 50 J

Classification:

EN ISO 2560-A E 42 0 R 12
AWS A5.1 E 6013

Approvals:

LR 2m
CE
DNV 2

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	71432500	55-100	23	0,62	81	0,8	50
3,2	450	71433200	75-140	23	0,67	36	1,2	72
3,2	350	71433235	75-140	23	0,67	48	1,2	54
4,0	450	71434000	110-190	25	0,64	26	1,7	81
5,0	450	71435000	140-265	29	0,65	16	2,7	77