

PRODUCT DATA SHEET

Afrox 75



Afrox 75 is a basic coated hydrogen controlled electrode, depositing a weld metal which contains 3,0-3,5% nickel. The electrode features good striking characteristics and a smooth stable arc with excellent slag removal and bead appearance. The nickel content of the weld metal ensures excellent impact properties at temperatures below -60°C with radiographic qualities which are consistently high. The electrode is suitable for use in all positions. This electrode has been designed primarily for welding fine grained low alloy steels containing 1,5-3,5% nickel, intended for service at temperatures to -100°C. It is also eminently suitable for welding fine grained structural steels having a tensile strength of up to 650 MPa and for welding weathering steel such as Corten.

Classifications		
AWS	A5.5	E8016-C2
EN	2560-A	E 46 6 3Ni B H5

Typical Chemical Analysis			
% Carbon	0,04 - 0,07	% Sulphur	0,025 max
% Manganese	0,45 - 0,75	% Phosphorous	0,025 max
% Silicon	0,2 - 0,5	% Nickel	3,0 - 3,5

Typical Mechanical Properties (All weld metal in the as welded condition)	
Tensile Strength	460 MPa min
0,2% Proof Strength	550 - 620 MPa
% Elongation on 5d	24 min
Charpy V-Notch at -60°C	60 J min
Charpy V-Notch at -73°C	50 J min
Charpy V-Notch at -101°C	40 J min

Packing Data			
Diameter (mm)	Current (A)	Pack Mass (kg)	Item Number
3,15	90 - 135	3 x 4,0	W075413
4,0	120 - 175	3 x 4,0	W075414

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