

# PRODUCT DATA SHEET

## Afrox 88 (88D3)



Afrox 88 (88D3) is a basic coated manganese molybdenum electrode recommended for use in all positions with the exception of vertical down. The electrode features a smooth and stable arc and gives excellent penetration. The slag release in all positions is excellent and the electrode operates with minimum spatter levels on both AC and DC. The product is used for the construction of boilers, pressure vessels and reactors commonly used in the petrochemical industry.

| Classifications |        |              |
|-----------------|--------|--------------|
| AWS             | A5.5   | E8018-D3     |
| EN              | 2560-B | E5516-3M3 H5 |

| Typical Chemical Analysis |           |               |            |
|---------------------------|-----------|---------------|------------|
| % Carbon                  | 0,12 max  | % Sulphur     | 0,03 max   |
| % Manganese               | 1,0 - 1,8 | % Phosphorous | 0,03 max   |
| % Silicon                 | 0,8 max   | % Molybdenum  | 0,4 - 0,65 |

| Typical Mechanical Properties (All weld metal in the as welded condition) |             |
|---|-------------|
| 0,2% Proof Stress   | 460 MPa min |
| Tensile Strength  | 550 MPa min |
| % Elongation on 50 mm   | 19 min      |
| Charpy V-Notch at -51°C   | 27 J min    |

| Packing Data (DC+ AC 70 OCV min) |             |                       |                |             |
|----------------------------------|-------------|-----------------------|----------------|-------------|
| Diameter (mm)                    | Current (A) | Electrode Length (mm) | Pack Mass (kg) | Item Number |
| 3,15                             | 90 - 135    | 350                   | 3 x 4,0        | W075453     |
| 3,15                             | 135 - 200   | 380                   | 3 x 6,0        | W075454     |
| 4,0                              | 180 - 260   | 450                   | 3 x 6,0        | W075455     |

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