PRODUCT DATA SHEET

Afrox TM-44

TM-44 is an outstanding high deposition self-shielded tubular wire that is used to weld mild and medium carbon steels. It is ideal for either single or multi-pass welding, and provides outstanding performance with deposition rates of up to 20 kg/h and deposition efficiencies of 84% or better. This electrode produces a globular type transfer with an arc that is not affected by drafts or moderate wind. It is specifically designed to desulphurise the weld metal and resist cracking. The product is recommended for applications such as machine fabrication, certain ship equipment, industrial and heavy equipment repair.

Classifications

AWS	A5.20	E70T-4
EN	17632-A	T 46 Z W N 4 H10

Approvals

American Bureau of Shipping E70T-4 (AWS A5.20)
Canadian Welding Bureau E4802T-4-CH

Typical Chemical Analysis (All weld metal)

% Carbon	0,27	% Phosphorous	0,008
% Manganese	0,45	% Aluminium	1,36
% Silicon	0,3	% Nickel	0,01
% Sulphur	0,004		

Typical Mechanical Properties (All weld metal using CO_2 gas)

Yield Strength	476 MPa
Tensile Strength	635 MPa
% Elongation on 50 mm	22

Welding Data (DC+)

Diameter (mm)	Position	Current		Optimum Settings		Deposition Rates (kg/h)	Electrode Stick Out (mm)
		Amps (A)	Volts (V)	Amps (A)	Volts (V)		
2,0	Flat/horizontal	290 - 370	31	330	30	5,0 - 7,3	50,0
2,4	Flat/horizontal	250 - 500	28 - 34	400	31	4,0 - 12,7	65,0

Packing Data

Diameter (mm)	Pack Mass (kg)	Package	Item Number
2,0	22,0	Coil	W081033
2,4	22,0	Coil	W081011
2,4	270,0	Drum	W081012

For more information contact the Afrox Customer Service Centre Tel: 0860 02 02 02
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