

PHOENIX SPEZIAL D

Double-coated basic stick electrode

Main benefit

Double coated electrode both for welding on site and in the shop.



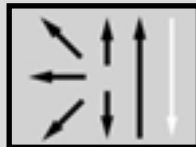
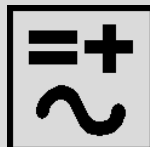
Product features	Product benefits	User benefits
» Double coated electrode	» Good gap bridging ability	» Easy welding on site even with different gaps
» Easy handling in all position	» Stable arc, very good welding characteristics	» Fast welding, less preparation leads to high productivity
» Approved for root pass	» Full slag cover on both sides of the root	» Save root runs with high productivity
» Available in Dry System vacuum packs	» Welding directly out of the package without re-drying	» Less time for preparation, always safe packed, fresh stick electrodes



Typical applications

- » Steel constructions
- » Tank construction
- » Structural steelworks

PHOENIX SPEZIAL D


Classifications		Operating data	
EN ISO 2560-A	AWS A5.1 / SFA-5.1	Welding positions	Polarity
E 42 3 B 1 2 H10	E7016		

Typical analysis of all weld metal, wt. %			
	C	Si	Mn
	0.06	0.65	1.05

Mechanical properties, all weld metal (single values typical)						
	Condition	Yield strength $R_{p0.2\%}$ MPa	Tensile strength R_m MPa	Elongation A ($L_0=5d_0$) %	CVN Impact toughness ISO-V KV J	
					20 °C	-30 °C
	Untreated, as welded	440 (≥ 420)	550 (500 – 640)	28 (≥ 20)	170	50 (≥ 47)

Steels to be welded	
EN	ASTM
Steels up to a yield strength of 420 MPa (60 ksi) S235JR-S355JR, S235JO-S355JO, S235J2-S355J2, S275N-S420N, S275M-S420M, P235GH-P355GH, P355N, P285NH-P420NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L245MB-L415MB, GE200-GE240	ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. A, C, D; A 662 Gr. A, B, C; A 678 Gr. A, B; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X56, X60

Approvals
TÜV (10572), DB (10.138.12), CE

Carton Packaging	Dry System Vacuum Packaging
 <p>Weight: ~ 4.1 kg</p> <p>Diameter: 2.5 x 350 mm 3.2 x 350 mm 3.2 x 450 mm 4.0 x 450 mm 5.0 x 450 mm</p>	 <p>Weight: DrySys 20: ~1.2 kg DrySys 30: ~ 2.1 kg</p> <p>Diameter: 2.5 x 350 mm 3.2 x 350 mm 3.2 x 450 mm 4.0 x 450 mm 5.0 x 450 mm</p>