



PHOENIX SH SCHWARZ 3

Mo-alloyed, acid-coated stick electrode

Key feature
Mo-alloyed stick electrode with particular adjusted Si-content.

Product features	Product benefits	User benefits
» Adjusted Si-content	» Optimized for galvanized plates	» Clean and smooth weld seams after galvanizing the parts



Typical application

- » Steel construction – galvanized parts
- » Galvanizing trays



Picture:
Phoenix SH Schwarz 3 avoids such
vermeidet derart erhabenen Schweißnähte. Dieser Effekt
entsteht bei zu hohem Si-Gehalt im Schweißgut

Phoenix SH Schwarz 3 is a very particular electrode. Their chemical composition is optimized for welding galvanized plates.

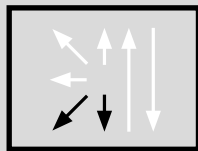
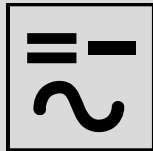
We do not mean the over-welding of galvanized plates. Here we mean the welding of plates, which will be galvanized after welding.

This is necessary for new parts. Only doing it that way, the welding seam is safe against corrosion due to the Zn-coating too.

In order to optimize this protection, the Zn-coating must be build smooth and constant over base material and weld seam.

Phoenix SH Schwarz 3 supports the building of the coating ideal.

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Classifications		Operating data	
EN ISO 2560-A	AWS A5.1 / SFA-5.1	Welding positions	Polarity
E 42 0 Mo A 1 2	E7020-G		

Mechanical properties, all weld metal (single values typical)				
	C	Si	Mn	Mo
	0.1	0.08	0.6	0.45

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 0 °C	
	As welded	460 (≥ 420)	560 (500 – 640)	24 (≥ 20)	80	70 (≥ 47)

Steels to be welded	
EN	ASTM
ARMCO Stähle	

Approvals
CE

Carton Packaging	
	Weight: ~ 6.7 kg Diameter: 4.0 x 450 mm 5.0 x 450 mm