

Standards

TS 3623 EN 12536	: O I
EN 12536	: O I
AWS A5.2	: R 45

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn
0.07	0.1	0.5

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))
min. 245	340 - 440	min. 35 J	min. 14

Features and Applications

- Oxy-acetylene / gas welding rod to be used for flame welding of all types of machinery parts made of unalloyed steels
- Body, exhaust, thin sheet pipe welding
- Neutral flame should be used

Welding Positions

Flame Adjustment

Neutral Flame

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
3010300000	1.60 x 1000	1/16 x 39"	5	Carton Box
3010300001	2.00 x 1000	5/64 x 39"	5	
3010300002	2.40 x 1000	3/32 x 39"	5	
3010300003	3.20 x 1000	1/8 x 39"	5	
3010300004	4.00 x 1000	5/32 x 39"	5	
3010300005	5,00 x 1000	3/16 x 39"	5	

Approvals: CE, SEPRO