

- Ilmenite Type Electrode
- All Positional Capabilities
- Ideal For Welding Thick And Thin Plates (1.6mm to 20mm)

WELDING POSITIONS :

**DESCRIPTION AND APPLICATIONS**

POWERWELD G-200 is an ilmenite type electrode designed for putting emphasis on both usability and weldability. Its suitable for butt and fillet welding in all position. These electrode provides very stable arc, easy slag removable and smooth appearance. The mechanical properties, crack resistance and X-Ray quality of weld deposits are excellent.

Typical applications include welding of bridges, shipbuilding and repairs, machineries, rolling stock, pressure vessels and other heavy structure fabrication.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	P	S
0.09	0.45	0.11	0.018	0.012

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES•

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
390 N/mm ²	445 N/mm ²	29%	95J @ 0°C

- in "as welded" condition.

OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE • (amps)	PACKAGING (kg)	
			PKT	CTN
2.6	300	60 - 90	5	20
3.2	400	85 - 140	5	20
4.0	400	130 - 190	5	20
5.0	400	180 - 260	5	20

- Recommended for DC+ or AC (minimum 45 OCV) operation