



P 47D

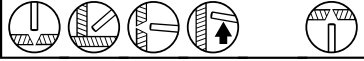
SMAW - (Stick) - MMA
Un-alloyed

Date: 2007-10-19
Revision: 20

Description:

P 47D is a basic double coated low hydrogen AC/DC electrode for welding mild and medium tensile steels in all positions except vertical down. It has an exceptionally stable arc making it particularly suitable for root passes. The electrode can be used on small welding transformers with a low OCV and operates with minimal spatter to deposit smooth weld beads featuring easy slag detachability and excellent mitre fillet profile. P 47D is very easy to strike and combines good metallurgical quality with extreme ease of use, making it ideal for general repair and maintenance applications.

Welding positions:



Coating type:

Basic

Welding current:

DC +, AC OCV ≥ 55 V

Hydrogen content / 100 g weld metal

≤10 ml

Metal recovery:

98%

Redrying temperature:

350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,25	0,60				
Typical	0,07	0,7	0,9	0,015	0,015		
Max	0,10	0,75	1,60	0,030	0,020	0,30	0,30

	Mo	Cu	V	Nb
Min				
Typical				
Max	0,30	0,20	0,08	0,05

Mechanical properties

	<u>Specified</u>	<u>Typical</u>	<u>PWHT Typical</u>
Yield strength, Re:	≥420 MPa	465 MPa	400 MPa
Tensile Strength, Rm:	510-610 MPa	550 MPa	510 MPa
Elongation, A5	≥ 22%	26%	31%
Impact energy, CV:	-20 °C • ≥47 J	-20 °C • 60 J	-20 °C • 100 J

Classification:

EN 499	E 42 2 B 12 H10
EN ISO 2560-A	E 42 2 B 12 H10
AWS A5.1	E 7016

Approvals:

DB	Kennblatt Nr. 10.042.05
TÜV	
CE	

Note

PWHT 600 C, 1 h

Product data

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/kg electrodes	No. of electrodes/kg weld metal	Kg weld metal/hour arc time	Burn-off time/electrode (sec.)
2,5	350	71492500	60-90	25	0,65	77	0,8	53
3,2	450	71493200	80-140	25	0,67	36	1,3	66
3,2	350	71493235	80-140	25	0,67	45	1,3	52
4,0	450	71494000	130-200	25	0,69	22	1,7	76