



P 52T

SMAW - (Stick) - MMA
Un-alloyed

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Revision: 8

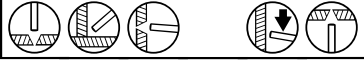
Description:

P 52T is a basic-coated low hydrogen electrode especially designed for tack welding mild and higher strength steels up to 500 MPa. It produces a flat-to-concave weld deposit exhibiting high ductility which minimises the risk of cracking in highly restrained joints. The electrode is easy to use in the vertical -down position, combined with excellent restriking and slag removal characteristics. P 52T has special slag properties that make it highly suitable for tack welding joints prior to using FCAW.

Applications:

Tack welding structural steels used in general fabrication, ship building, bridge construction and heavy plant.

Welding positions:



Coating type:

Basic

Welding current:

DC+, AC OCV > 50 V

Hydrogen content / 100 g weld metal

≤ 5 ml

Metal recovery:

125 %

Redrying temperature:

350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,30	0,80				
Typical	0,06	0,40	0,95	0,015	0,010		
Max	0,09	0,60	1,20	0,020	0,015	0,1	0,2

	Mo	V
Min		
Typical		
Max	0,1	0,08

Mechanical properties

	Specified	Typical
Yield strength, Re:	>420 MPa	440 MPa
Tensile Strength, Rm:	500 MPa	540 MPa
Elongation, A5	> 22 %	30 %
Impact energy, CV:	-20 °C • > 47 J	-20 °C • > 100 J

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	71522500	60-110	21	0,76	60		
3,2	350	71523235	110-160	25,5	0,76	36		
4,0	350	71524035	160-210	27	0,78	24		

Classification:

EN 499	E 42 2 B 35 H5
EN ISO 2560-A	E 42 2 B 35 H5
AWS A5.1	E7048-H4

Approvals:

DNV	3YH5
BV	3YHH
LR	3YH5
GL	3YH5
CE	

Note

Core wire:
S ≤ 0.015%
P ≤ 0.015%
N ≤ 0.008%