



P 43

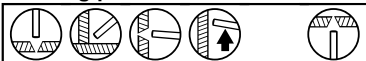
SMAW - (Stick) - MMA
Un-alloyed

Date: 2003-06-19
Revision: 15

Description:

P 43 is a medium-coated rutile electrode intended for welding light to medium sections in mild steel. The electrode operates with a very smooth arc and is suitable for all positions except vertical down. It is easy to strike and re-strike and produces a self-detaching slag leaving a finely rippled bead appearance. With its excellent bead surface and smooth transition with the base material P 43 is ideal for butt and fillet welding of sheet metal work.

Welding positions:



Coating type:

Rutile

Welding current:

DC +/-, AC OCV ≥ 50 V

For root passes: DC -

Metal recovery:

95%

Redrying temperature:

80-90°C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,30	0,30				
Typical	0,07	0,4	0,5	0,015	0,015		
Max	0,11	0,60	0,75	0,030	0,020	0,1	0,2

	Mo	Cu	V	Nb
Min				
Typical				
Max	0,1	0,2	0,05	0,05

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥ 420 N/mm ²	480 N/mm ²
Tensile Strength, Rm:	510-560 N/mm ²	550 N/mm ²
Elongation, A5	$\geq 22\%$	24%
Impact energy, CV:	0°C • ≥ 47 J	0°C • 50 J

Classification:

EN 499-95 E 42 0 R 12
AWS A5.1-91 E 6013

Approvals:

LR 2m
SVK
BV 2
Force
DNV 2
UDT E 42 0 R 12
Inspecta
ABS 2

Note

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

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.)
1,60	300	71431600	25-60	22	0,5	233	0,5	27
2,00	300	71432000	40-80	22	0,6	142	0,6	34
2,50	350	71432500	55-100	23	0,62	81	0,8	50
3,25	450	71433200	75-140	23	0,67	36	1,2	72
3,25	350	71433235	75-140	23	0,67	48	1,2	54
4,00	450	71434000	110-190	25	0,64	26	1,7	81
4,00	350	71434035	110-190	25	0,64	33	1,7	60
5,00	450	71435000	140-265	29	0,65	16	2,7	77
6,00	450	71436000	220-350	30	0,65	11	3,9	90