Processing information

Welding positions:

Polarity:

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High-quality welds require appropriate weld preparation, well-trained personnel, and compliance with recognised standards of good practice.

Application

Rutile-basic coated special-purpose electrode with a conducting and waterrepellent coating for manual wet underwater welding. Suitable for assembly and repair welding in up to 20 m water depth for offshore and harbour construction, shipbuilding, and steel hydraulic engineering.

Field

use

Underwater Electrodes for Welding

Characteristic

rutile-basic-coated

Standards

DIN 2302
E 38 0 Z RB 2 UW 20 fr

Approvals

DNV·GL

Materials
Mild steels with a carbon equivalent value CEV (IIW) of 0.4% maximum (CEV = C+Mn/6+(Cr+Mo+V)/ 5+(Ni+Cu)/15 in %).
The welding electrode is not suitable for welding of higher-strength steels. These materials can be subject to cracking from underwater welding.

All Weld Metal Mechanical Properties					
Heat Treatment					AW
Weld Metal Composition [%]					
C	Si	Mn	Mo		
0,05	0,25	0,5	0,5		
Yield strength Re [MPa]					> 440
Tensile Strength Rm [MPa]					> 480
Charpy Impact Value ISO -V [J/0 °C]					≥ 30

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.995.323	3,25/350	140 – 190	4,3	115	37,4

THE ORIGINAL MADE IN GERMANY SINCE 1920

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