

# ROWELD-HT 75

BASIC COATED, EXTRA LOW HYDROGEN ELECTRODE IDEALLY SUITED FOR WELDING HIGH STRENGTH STEELS, Q&T STEELS.

BASIC ALLOY: FE, MN, SI, NI, CR  
 AWS/SFA-5.5: E 10016 G  
 EN ISO 18275-B E 62 18-G A H5

## KEY FEATURES:

A basic type, medium-heavy coated, hydrogen-controlled iron powder electrode for heavy-section, constrained joints in high-tensile structural steels. This electrode produces weld deposits of good notch toughness, extremely low hydrogen content and good crack resistance. It provides good X-ray and soundness

## APPLICATIONS

- Welding of 80kgf/mm<sup>2</sup> class high tensile steel for pressure vessels, penstocks, bridges, offshore constructions, and industrial machinery and construction machinery.

## RE-DRY CONDITION:

- Dry the electrodes at 350°C 400°C(662~752°F) for about one hour before use

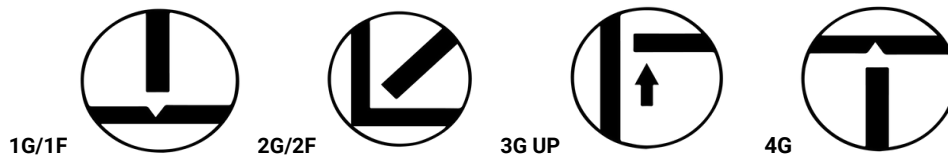
## CHEMICAL COMPOSITION:

C	Mn	Si	Ni	Mo	S&P	Cr
0.1 max	1.00 - 1.60	0.60 Max	1.00-2.00	0.60 Max	0.025 Max	0.4 max

## MECHANICAL PROPERTIES:

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT	Hydrogen contains
590min.	690min.	17 min	-50C: 50-80 Joules	less than 4mL/100g

## WELDING POSITION



## DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (DIA)	Size (inch) (DIA)	Current Condition (DC+/AC 70V) Amps	Kg./pkt.	KG/Case
2.50/ 2.40	3/ 32"	70-100	5	20
3.15/ 3.20	1/ 8"	100-130	5	20
4.00	5/ 32"	140-180	5	20
5.00	3/ 16"	190-230	5	20