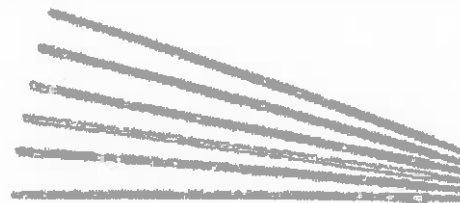




## UNIQUE WELDING ALLOYS

a division of Weidamex (Pty) Ltd



### Classifications

PRODUCT	ISOARC 112
DIN	E 43 32 R (C) s
ISO	E 43 2 R 15

### Chemical Analysis

Carbon	0.08
Manganese	0.6
Phosphorous	0.012
Silicone	0.3
Sulphur	< 0.03

### Mechanical Properties

TENSILE	540 - 600 N/mm <sup>2</sup>
YIELD	>480 N/mm <sup>2</sup>
ELONGATION	> 28%

### Welding Positions:



### Descriptions

Mild Steel General Purpose

### Characteristics

The ideal, general purpose electrode. ISOARC 112 is a heavy-coated rutile electrode that gives a quality finish. The arc is easy to control and produces minimal spatter. Low amperage performance prevents distortion. Contact welding enables thin sections to be welded easily. Any slag is easily removed.

### Applications

ISOARC 112 is used in workshops for welds requiring all round good weld appearance. Ideal for burglar bars, gates, framework, steel cabinets, piping, boilers, component manufacture and fabrications

### Procedures

Avoid excessive amperage, and use AC or DC straight polarity. Maintain a short arc and use a stringer-bead or weaving technique. Light gauge material may be contact welded. Slag is easily removed with minimal impact on the area surrounding the weld.

### Redrying

Should electrodes become moist redry at 120° C for 1 hour.

Diameter	Length	Current	Pack Mass	Item No
2.0	300mm	30 - 70A	5kg	E11220
2.5	350mm	70 - 110A	5kg	E11225
3.2	350mm	100 - 150A	5kg	E11230
4.0	450mm	120 - 200A	5kg	E11240
5.0	450mm	180 - 260A	5kg	E11250
6.3	450mm	220 - 300A	5kg	E11263