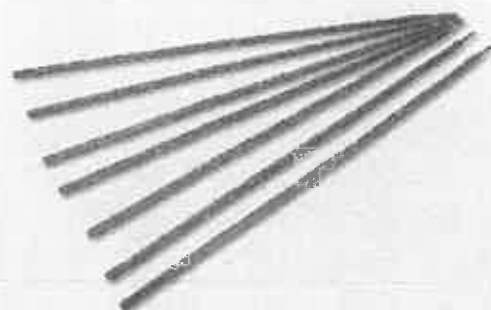




UNIQUE WELDING ALLOYS

a division of Weldmax (Pty) Ltd



Classifications

PRODUCT ISOARC 103

Mechanical Properties

TENSILE >520-580 N/mm²
 YIELD >430-500 N/mm²
 ELONGATION >33%

Chemical Analysis

Carbon 0.12
 Manganese 1.2
 Phosphorous 0.02 Max
 Silicone 0.60
 Sulphur 0.02 Max

Welding Positions



Characteristics

ISOARC 103 is specially formulated to control heat input and reduce distortion. It is easy to use in all welding positions, has a stable arc and easily controls slag. Suitable DC only.

Applications

ISOARC 103 is widely used in the construction and fabrication industry on beams, angles, channel iron, pipelines, pressure tanks, railway carriages, ship building and by maintenance repair specialists.

Procedures

Use ISOARC 103 with normal low-hydrogen techniques. First class results will be obtained using medium to short arc. Avoid weaving

Redrying

Should electrodes become moist re-dry at 350°C for 1 hour.

Diameter	Length	Current	Pack Mass	Item No
2.5	350mm	70-90A	4kg	E10325
3.2	350mm	100-145A	4kg	E10332
4.0	450mm	140-180A	5kg	E10340
5.0	450mm	180-240A	5kg	E10350
6.3	450mm	250-300A	5kg	E10363