

SMAW Electrodes

D200

AWS A5.1M E4319 / A5.1 E6019
JIS Z 3211 E4319U
ISO 2560-A-E 35 2 RA

Product Features:

- Ilmenite type covered electrode for mild steel.
- Available for all positions, good crack and porosity resistance.
- Easy slag removal.
- Good for RT examination, good mechanical properties.
- High arc concentration and good bead appearance.

Applications:

- Suitable for welding of thickness ≤ 20 mm steel structures on shipbuilding, vehicles, buildings, bridges, tanks, pressure vessels and general mechanical structures.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Fe
0.08	0.27	0.35	0.026	0.008	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-20°C) J
462	500	28	68

Size (mm) & recommended welding parameters (A) AC or DC±

Diameter / Length	2.6/300	3.2/350	4.0/400	5.0/450	6.0/450
Flat position	60~80	100~140	150~190	190~240	240~320
Vertical / overhead position	50~70	80~110	120~160	150~200	-

Note:

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