



P 47D SPEZIAL

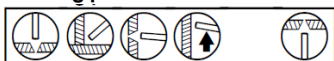
SMAW - (Stick) - MMA
Un-alloyed

Date: 2022-06-20
Revision: 1

Description:

P 47D SPEZIAL is a basic double coated AC/DC electrode for welding mild and medium tensile steels in all positions except vertical down. It has an exceptional arc stability and weldability and delivers high quality weld deposits with reliable notch toughness to -40°C. P 47D SPEZIAL is manufactured using a unique twin coating extrusion process, which means all the arc stabilizing elements are concentrated in the inner coating. This delivers significantly improved arc stability and control for all applications. P 47D SPEZIAL is very easy to strike/restrike and offers extreme ease of use, making it ideal for general repair and maintenance applications.

Welding positions:



Coating type:

Basic

Welding current:

DC+, AC OCV ≥ 45 V

Hydrogen content / 100 g weld metal

≤ 10 ml

Metal recovery:

100%

Redrying temperature:

350 °C, 2h

Chemical composition, wt. %

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,05	0,42	1,16	0,013	0,006		
Max	0,15	0,75	1,60	0,035	0,035	0,20	0,30

	Mo	Cu	V	Nb
Min				
Typical				
Max	0,2	0,3	0,05	0,05

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥ 420 MPa	460 Mpa
Tensile Strength, Rm:	500-640 Mpa	560 Mpa
Elongation, A5	≥ 22%	28%
Impact energy, CV:	-40 °C • ≥47 J	-20 °C • 130 J -40 °C • 110 J

Product data:

Diam.mm	Length mm	Current A	Kg weld metal/kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/electrode (sec)
2,5	350	60-90	0,62	82	0,7	55
3,2	350	90-135	0,62	50	1,1	65
4,0	450	140-240	0,60	24	1,7	89

Classification:

EN ISO 2560-A E 42 4 B 12 H10
AWS A5.1 E 7016

Approvals:

LR (Pending) 4Ym H10
DNV (Pending) 3Y H10
CE

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