



# P 52T

SMAW - (Stick) - MMA  
Un-alloyed

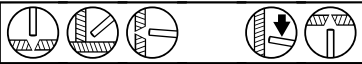
Date:	2013-05-30
Revision:	10

**Description:**

P 52T is a basic-coated low hydrogen electrode especially designed for tack welding mild and higher strength steels up to 500 MPa. It produces a flat-to-concave weld deposit exhibiting high ductility which minimises the risk of cracking in highly restrained joints. The electrode is easy to use in the vertical -down position, combined with excellent restriking and slag removal characteristics. P 52T has special slag properties that make it highly suitable for tack welding joints prior to using FCAW.

**Applications:**

Tack welding structural steels used in general fabrication, ship building, bridge construction and heavy plant.

**Welding positions:****Coating type:**

Basic

**Welding current:**

DC+, AC OCV > 50 V

**Hydrogen content / 100 g weld metal**

≤ 5 ml

**Metal recovery:**

125 %

**Redrying temperature:**

375-400 °C, 2h

**Chemical composition, wt.%**

	C	Si	Mn	P	S	Cr	Ni
Min		0,30	0,80				
Typical	0,06	0,40	0,95	0,015	0,010		
Max	0,09	0,60	1,20	0,020	0,015	0,1	0,2

	Mo	V
Min		
Typical		
Max	0,1	0,08

**Mechanical properties**

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	>420 MPa	440 MPa
Tensile Strength, Rm:	500 MPa	540 MPa
Elongation, A5	> 22 %	30 %
Impact energy, CV:	-40 °C • > 47 J	-20 °C • 100 J -40 °C • 70 J

**Classification:**

EN ISO 2560-A                      E 42 4 B 35 H5  
AWS A5.1                              E7048-H4

**Approvals:**

CE  
BV                                      3YHH  
LR                                      3YH5  
GL                                      3YH5  
DNV                                    3YH5

**Note**

Core wire:  
S ≤ 0.015%  
P ≤ 0.015%  
N ≤ 0.008%

**Produkt data:**

Diam.mm	Length mm	Product code	Current A	Voltage V	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	71522500	60-110	21	0,76	60		
3,2	350	71523235	110-160	25,5	0,76	36		
4,0	350	71524035	160-210	27	0,78	24		