



P 40

SMAW - (Stick) - MMA
Un-alloyed

Date:	2013-10-21
Revision:	23

Description:

P 40 is a thicker-coated, all positional rutile-cellulosic electrode suitable for general purpose applications in mild steel. It is particularly recommended for vertical up and overhead applications, but can also be used in the vertical down position. The electrode welds with a smooth, low spatter arc to produce a finely rippled bead surface and good slag detachability. Combined with good striking/restriking and tolerance to large gaps, the electrode is very easy to use and recommended for all-round fabrication work.

Welding positions:

1 2 3 4 5 6

Coating type:

Rutile-cellulosic

Welding current:

DC+/-, AC OCV ≥ 50 V

For root passes: DC-

Metal recovery:

95%

Redrying temperature:

90 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,3	0,5				
Typical	0,09	0,6	0,7	0,015	0,015		
Max	0,10	0,8	1,0	0,030	0,020	0,1	0,2

	Mo	Cu	V	Nb
Min				
Typical				
Max	0,1	0,2	0,05	0,05

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥420 MPa	510 MPa
Tensile Strength, Rm:	510-640 MPa	580 MPa
Elongation, A5	≥ 22%	24%
Impact energy, CV:	0 °C • ≥47 J	0 °C • 50J

Classification:

EN ISO 2560-A	E 42 0 RC 11
AWS A5.1	E 6013

Approvals:

CE	
DNV	2
LR	2m, 2Ym
GL	2Y

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	71402500	60-90	22	0,57	90	0,7	61
3,2	350	71403200	90-150	23	0,58	55	1,3	54
4,0	350	71404000	130-190	24	0,57	36	1,6	62