



P 44

SMAW - (Stick) - MMA
Un-alloyed

Date: 2013-10-21
Revision: 25

Description:

P 44 is a thinner-coated, all positional, rutile-cellulosic electrode for general purpose fabrication in mild steel, but with exceptionally good vertical down operability. It can be welded in all positions without the need to alter the current setting and is particularly suitable for working conditions with restricted space or difficult access. The electrode is easy to use where joint fit-up is poor or outside corner joints are to be welded. Excellent strike and restriking characteristics make it ideal for tack-welding. P 44 is highly tolerant to plate contaminated by rust, mill scale, paint, dirt etc., making it suitable for repair and maintenance work as well as shipyard applications.

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		0,20	0,35				
Typical	0,07	0,4	0,6	0,015	0,015		
Max	0,10	0,60	0,85	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:	≥380 MPa	460 MPa
Tensile Strength, Rm:	470-560 MPa	530 MPa
Elongation, A5	≥22%	24%
Impact energy, CV:	0 °C • ≥47 J	0 °C • 60 J

Classification:

EN ISO 2560-A E 38 0 RC 11
AWS A5.1 E 6013

Approvals:

DNV 2
DB Kennblatt Nr. 10.042.04
CE
LR 2m, 2Ym
TÜV

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	71442500	70-100	22	0,69	80	0,8	46
3,2	350	71443200	90-150	23	0,69	49	1,3	51
4,0	350	71444000	120-190	23	0,7	34	1,6	61