

Phoenix Nautica 20

Classifications

underwater electrode

DIN 2302

E 42 0 Z RR 2 UW 10 fr

Characteristics and field of use

Covered electrode for manual metal arc welding under hyperbaric wet conditions down to 20 msw. Very good weldability in vertical down position.

Base materials

S235JRG2 – unalloyed and fine grained structural steels. Higher strength structural steels should not be welded with this type of electrodes as these materials are susceptible to “Hydrogen Induced Cold Cracking (HICC)” when welded in wet environment. The carbon content of the parent metal should not exceed 0.15%.

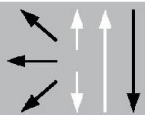
Typical analysis in %

C	Si	Mn	Mo
0.08	0.30	0.55	0.50

Mechanical properties of the weld metal

Heattreatment	0.2 %-Yield strength	Tensile strength	Impact values CVN
	MPa	MPa	J
AW	420	500	38

Welding positions



Current type DC (+) / DC (-)

Approvals

GL

Form of delivery and recommended welding parameters

Electrodes \varnothing mm x L	Amperage [A]
3.2 x 350	150 – 200

