

PH68



SUMMARY

- > General purpose rutile type electrode
- > Produces a rapid fast freezing slag
- > One current setting can be used for welding in all positions

IDENTIFICATION

Coating - Tan **Tip** - Red **Imprint** - PH68 6013 4313A

CLASSIFICATION

- > AS/NZS 4855B E4313A
- > AWS A5.1 E6013

DESCRIPTION AND APPLICATION

This medium-heavy coated rutile electrode produces a rapid freezing slag. Its large droplet type of arc makes it ideal for poor fitting work or where large gaps have to be bridged. It is perfect for site work because with one current setting welds can be done in all positions. Excellent for galvanised steel. The Weldwell PH68 is suitable for vertical down welding because of the excellent slag control.

The Weldwell PH68 is suitable for welding in sharply curved and poorly fitting grooves, as well as inclined grooves. It melts off in fairly coarse droplets and is suitable for bridging large gaps. The very rapidly solidifying slag prevents the liquid weld metal from flowing away when welding is done in difficult positions, especially pipe welding.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELD CURRENT RANGE * (A)
2.5	305	60 - 95
3.2	380	70 - 125
4.0	380	130 - 170

*Recommended for DC +/- or AC (minimum 50 OCV).
Voltage is determined by arc current and electrode arc length.
Arc voltage shown is typical and is only to be used as a guide.

SHIPPING APPROVAL

- > **Lloyd's Grading** - DXVu0 BF 1
- > **BV Grade** - 1
- > **ABS Grade** - 1

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si
0.08	0.4	0.46

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Strength	443 MPa
Tensile Strength	495 MPa
Elongation	29%
CVN Impact Values	87J @ +20° C

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING		APPROX. NO. OF RODS PER KG	PART NO.
	KG PER PACKET	PACKETS PER CARTON		
2.5	2.5	5	172	PH6825
3.2	5.0	3	163	PH6832
4.0	5.0	3	109	PH6840

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