

PRODUCT DATA SHEET

GENERAL PURPOSE ELECTRODES

PH48A



SUMMARY

- > General purpose rutile type electrode
- > An all positional electrode.
- > Easy starting and restarting properties

IDENTIFICATION

Coating - Tan **Tip** - Silver **Imprint** - PH48A 6013 4313A

CLASSIFICATION

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

DESCRIPTION AND APPLICATION

The Weldwell PH48A is a rutile electrode for all positional general purpose welding of mild steel. The arc stability on low open circuit voltages makes it excellent for use on 230V single phase welding machines. The slag has quicker freezing properties than many types of similar class electrodes, this makes it suitable for out of position welding. It also offers quite remarkable tolerance to bad lift-up. The easy starting and restarting properties combined with quiet running makes it a good electrode for welding galvanised steel and pipe.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELD CURRENT RANGE * (A)
2.5	305	70 - 100
3.2	380	90 - 135
4.0	380	130 - 180

*Recommended for DC- or AC (minimum 45 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** - DXVuO BF 2Ym No
- > **BV Grade** - 2
- > **ABS Grade** - 2

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si
0.04	0.50	0.40

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Strength	467 MPa
Tensile Strength	521 MPa
Elongation	31%
CVN Impact Values	59J @ 0°C

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING		APPROX. NO. OF RODS PER PKT	PART NO.
	KG PER PACKET	PACKETS PER CARTON		
2.5	2.5	5	172	PH48A25
3.2	5.0	3	163	PH48A32
4.0	5.0	3	109	PH48A40

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Issue CA - July 2020