

PH56S



SUMMARY

- > A low hydrogen controlled electrode
- > Suitable for all positions
- > Deposits a very pure weld
- > X-ray qualities

IDENTIFICATION

Coating - White **Tip** - Red **Imprint** - PH56S 7016 4916A

CLASSIFICATION

- > AS/NZS 4855B 4916AU H5
- > AWS A5.1 E7016 H8

DESCRIPTION AND APPLICATION

The Weldwell PH56S is an all-positional low hydrogen electrode which deposits a very pure weld metal with exceptional mechanical and X-ray properties. For use on mild, unalloyed micro alloyed and low alloy steels, also for steels to LT 40 spec. Used with a short arc and reasonably slow travel speeds.

The PH56S is widely adopted for offshore fabrication to ensure consistent results, with the assurance of high impact values in the as-welded condition and further improved by stress relieving. COD testing confirms excellent fracture toughness after stress relieving. Many years of successful use in offshore work provides an immense range of approved procedures.

OPERATIONAL DATA

| ELECTRODE SIZE (MM) | ELECTRODE LENGTH (MM) | WELD CURRENT RANGE * (A) |
|---------------------|-----------------------|--------------------------|
| 2.5 | 305 | 60 - 100 |
| 3.2 | 380 | 85 - 140 |
| 4.0 | 380 | 100 - 180 |

*Recommended for DC +/- or AC (minimum 70 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 4Y H5
- > **BV Grade** - 3Y HH
- > **ABS Grade** - 3Y

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

| C | Mn | Si |
|------|------|------|
| 0.05 | 1.11 | 0.34 |

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

| | |
|-------------------|--------------|
| Yield Strength | 497 MPa |
| Tensile Strength | 589 MPa |
| Elongation | 28% |
| CVN Impact Values | 107J @ -40°C |

PACKAGING DATA

| ELECTRODE SIZE (MM) | PACKAGING | | APPROX. NO. OF RODS PER KG | PART NO. |
|---------------------|---------------|--------------------|----------------------------|----------|
| | KG PER PACKET | PACKETS PER CARTON | | |
| 2.5 | 2.2 | 5 | 131 | PH56S25 |
| 3.2 | 5.0 | 3 | 151 | PH56S32 |
| 4.0 | 5.0 | 3 | 99 | PH56S40 |

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