



STORAGE AND RECONDITIONING OF CIGWELD HYDROGEN CONTROLLED ELECTRODES

Storage Environments:

Undamaged packs/cartons of Ferrocrafter and Alloycrafter electrodes stored at 50% R.H. or less and kept at 10-15°C (50-60°F) above ambient temperature with a maximum of 40°C (105°F) stored off the ground and away from walls in cupboards, containers or warehouses are expected to maintain their designated hydrogen levels indefinitely.

Moisture Re-absorption:

Cardboard packs/cartons of Ferrocrafter and Alloycrafter may lose their designated hydrogen status due to moisture re-absorption from poor storage environments. Where electrodes have been exposed to moisture or where hydrogen control is important, the following procedures are recommended for reconditioning.

Hermetically Sealed:

Hermetically sealed, hydrogen controlled electrodes are packaged with an air tight seal to maintain product in an original "FACTORY FRESH" condition for an indefinite period provided the seal is unbroken.

Reconditioning and Hydrogen/Moisture Requirements:

AS/NZS 1553.1 low "H10" hydrogen status and AWS A5.1 "H8" hydrogen status.	AS/NZS 1553.1 very low "H5" hydrogen status and AWS A5.1 "H4" very low hydrogen status.
FERROCRAFT 16TXP FERROCRAFT 7016 FERROCRAFT 55U FERROCRAFT 61 FERROCRAFT 18-Ni	FERROCRAFT 61 H4 ALLOYCRAFT 80-B2 ALLOYCRAFT 90 ALLOYCRAFT 110 ALLOYCRAFT 80-C1 ALLOYCRAFT 90-B3
Rebake for maximum of 2 hrs @ 300°C (570°F) in a vented oven and thereafter use From a hot box set at 100 - 120°C (210 - 250°F).	Rebake for maximum of 2 hrs @ 350°C (660°F) in a vented oven and thereafter use From a hot box set at 100 - 120°C (210 - 250°F).

FERROCRAFT 16TXP



TYPICAL ALL WELD METAL MECHANICAL

PROPERTIES:

Yield Stress.	460 MPa.
Tensile Strength	550 MPa.
Elongation	27%.
CVN Impact Values	90 J av @ -20°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.07%	Mn: 1.50%	Si: 0.65%
S: 0.010%	P: 0.015%	

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

7.0-7.5 mls of hydrogen / 100gms of deposited weld metal.

APPROVALS:

Lloyds Register of Shipping	Grade 3, 3Y H15.
American Bureau of Shipping	Grade 3H10, 3Y
Det Norske Veritas	Grade 3Y H10.

- ▲ "XP series" E4816 / E7016 Type Electrode.
- ▲ Great Operator Appeal / Hydrogen Controlled.
- ▲ LONGER 350mm 2.5mm Size For Fewer Electrode Change-overs and Less Wastage.
- ▲ Easy operation, reliable Grade 3 weld metal properties and low hydrogen status of Ferrocrafter 16TXP make the electrode ideal for maintenance welding jobs, including the repair of earth moving equipment and the "buttering" of steel sections prior to the application of hard surfacing.

Classifications:

AS/NZS 1553.1	E4816-2 H10.
AWS/ASME-SFA A5.1:	E7016 H8.

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Easyweld Handipack	Part No
2.5	350	53	50 - 90	5kg	15kg - 3 x 5kg		611562
2.5	350	53	50 - 90	2.5kg	15kg - 6 x 2.5kg		612562
3.2	380	28	85 - 140	5kg	15kg - 3 x 5kg		611563
3.2	380	28	85 - 140	2.5kg	15kg - 6 x 2.5kg		612563
4.0	380	19	135 - 190	5kg	15kg - 3 x 5kg		611564

Easyweld Blister Pack:

10 x 2.5mm/5 x 3.2mm rod Ferrocrafter 16TXP Blister Pack	322214
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- Ferrocrafter 16TXP is formulated to operate with AC (45 O.C.V min), DC+ or DC- polarity. The preferred polarity for fillet welding and fill and capping passes is DC+.

FERROCRAFT 16TXP – Hermetically Sealed



TYPICAL ALL WELD METAL MECHANICAL

PROPERTIES:

Yield Stress.	460 MPa.
Tensile Strength	550 MPa.
Elongation	27%.
CVN Impact Values	90 J av @ -20°C.

TYPICAL ALL WELD METAL ANALYSIS:

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TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

7.0-7.5 mls of hydrogen / 100gms of deposited weld metal.

* Reconditioned for 2 hours maximum @ 300°C

APPROVALS:

Lloyds Register of Shipping	Grade 3, 3Y H15.
American Bureau of Shipping	Grade 3H10, 3Y
Det Norske Veritas	Grade 3Y H10.

- ▲ Hermetically Sealed Ring Pull Cans.
- ▲ "XP series" E4816 / E7016 Type Electrode.
- ▲ Excellent Operator Appeal / Hydrogen Controlled.
- ▲ LONGER 350mm 2.5mm Size For Fewer Electrode Change-overs and Less Wastage.
- ▲ Easy operation, reliable Grade 3 weld metal properties and low hydrogen status of Ferrocrafter 16TXP make the electrode ideal for maintenance welding jobs, including the repair of earth moving equipment and the "buttering" of steel sections prior to the application of hard surfacing.

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AS/NZS 1553.1	E4816-2 H10.
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RELEASED
2ND QUARTER
2004

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Can	Carton	Easyweld Handipack	Part No
2.5	350	53	50 - 90	3kg	9kg - 3 x 3kg		613562
3.2	380	28	85 - 140	3kg	9kg - 3 x 3kg		613563
4.0	380	19	135 - 190	3kg	9kg - 3 x 3kg		613564

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