

SMOOTHCRAFT

45
ocv

DC
AC



- General purpose, rutile-ilmenite type electrode
- Outstanding operator appeal!
- Versatile, all positional capabilities
- Smooth mitre fillet welds with low spatter

Classifications:

AS/NZS 1553.1: (old)	E4113-0
AWS/ASME-SFA A5.1:	E6013

Description and Applications:

Smoothcraft is an easy-to-use general purpose, rutile-ilmenite electrode suitable for welding in the horizontal-vertical, vertical-up and overhead positions.

Smoothcraft produces smooth professional mitre fillet welds in all positions (except vertical-down) with very low spatter levels, positive re-strike (hot or cold) and self-releasing slag. Smoothcraft can be used with either AC (min. 45 OCV) or DC current.

Applications for Smoothcraft include the general workshop, field and structural welding of mild or galvanised steel components such as pipes, tanks, frames, fences and gates etc. Smoothcraft is particularly recommended for the lap and fillet welding of thin walled galvanised and mild steels where the low spatter levels and excellent edge wetting produce superior results.

Typical all weld metal mechanical properties:

Yield Stress	430 MPa
Tensile Stress	510 MPa
Elongation	28%
CVN Impact Values	60J av @0°C

Typical all weld metal analysis:

C: 0.08%	Mn: 0.43%	Si: 0.37%
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Approvals:

Lloyds Register of Shipping	Grade 2
American Bureau of Shipping	Grade 2
Det Norske Veritas	Grade 2

Packaging and Operating Data

AC (minimum 45 OCV) DC+ or DC- polarity.

MALAYSIA

Electrode Size mm	Electrode Length mm	Approx No. Rods/kg	Current Range (amps)	Poly Bag	Carton	Part No.
2.0	300	92	40 - 70	5kg	20kg - 4 x 5kg	614441L
2.5	350	46	60 - 100	5kg	20kg - 4 x 5kg	614442L
3.2	400	28	90 - 140	5kg	20kg - 4 x 5kg	614443L
4.0	400	19	135 - 180	5kg	20kg - 4 x 5kg	614444L
5.0	400	12	180 - 240	5kg	20kg - 4 x 5kg	614445L

ASIA - OTHER

Electrode Size mm	Electrode Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No.
2.5	350	46	55 - 90	5kg	15kg - 3 x 5kg	611042
3.2	350	29	90 - 135	5kg	15kg - 3 x 5kg	611043
4.0	400	20	135 - 180	5kg	15kg - 3 x 5kg	611044
5.0	400	13	180 - 240	5kg	15kg - 3 x 5kg	611045