

## Phoenix Spezial D

Stick electrode

## Classifications

unalloyed basic

EN ISO 2560-A:

AWS A5.1:

E 42 3 B 12 H10

E7016

## Characteristics and field of use

Double covered basic electrode. Outstanding welding characteristics on AC and DC in all positions except the vertical down; stable arc, good radiographic soundness. Useable in handicraft and industry for field and workshop applications. Redry for 2 h at 250 - 300 °C (482 - 572 °F).

## Base materials

S235JRG2 - S355J2, boiler steels P235GH, P265GH, P295GH, P355GH; fine grained structural steels up to S355N; pipe steels St 35, St 35.8, L210 - L360NB, GS-52, L290MB - L360MB; ASTM A27 and A36 Gr. all, A214, A242 Gr. 1-5, A266 Gr. 1, 2, 4, A283 Gr. A, B, C, D, A285 Gr. A, B, C, A299 Gr. A, B, A328, A366, A515 Gr. 60, 65, 70, A516 Gr. 55, A570 Gr. 30, 33, 36, 40, 45, A572 Gr. 42, 50, A606 Gr. all, A607 Gr. 45, A656 Gr. 50, 60, A668 Gr. A, B, A907 Gr. 30, 33, 36, 40, A841, A851 Gr. 1, 2, A935 Gr. 45, A936 Gr. 50; API 5 L Gr. B, X42-X56

## Typical analysis of all-weld metal (Wt-%)

C	Si	Mn		
0.06	0.65	1.05		

## Mechanical properties of all-weld metal

Heat Treatment	Yield strength 0.2%	Tensile strength	Elongation (L <sub>0</sub> =5 <sub>g</sub> 0)	Impact values ISO-V	
				+20°C	-30 °C
untreated	440	550	22	80	50

## Operating data



Polarity = + / ~

## Dimensions (mm)

## Amperage A

2.5 x 350	60-90
3.2 x 350	95-150
3.2 x 450	95-150
4.0 x 450	140-190
5.0 x 450	190-250

## Approvals and certificates

TÜV (03282.), DB (10.132.42), ABS, BV, DNV, GL, LR