



Product Data Sheet

O 'Oxy-fuel gas welding'

OK Gasrod 98.70

Signed by Mats Linde	Approved by Per Sundberg/Barbro Karlström	Reg no EN002350	Cancelling EN000335	Reg date 2004-08-06	Page 1 (1)
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REASON FOR ISSUE

General modification and adoption to new system.

GENERAL

Unalloyed bare welding rods for gas welding of unalloyed steels in applications such as tanks and pipings.

Alloy Type: Non alloyed steel (with 1 % Mn)

CLASSIFICATIONS Wire Electrode

EN 12536 OII
SFA/AWS A5.2 R60

APPROVALS

Not
applicable

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.1	0.03	0.15
Si	0.05	0.10	0.25
Mn	0.8	0.90	1.20
P	0.02		0.025
S	0.02		0.025
Cr			0.20
Ni			0.30
Mo			0.20
V			0.10
Cu			0.30
Al			0.02
	Comments:	Comments: a) Other elements each max 0.30 %, total max 0.50 %	

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal
	As welded Min
Rp0.2 (MPa)	300
Rm (MPa)	390
A4-A5 (%)	20