

ETC PH-RSP DW RSP



MMA Electrodes Stainless and Heat resistant steels

Semi-basic MMA electrode depositing austenitic-ferritic weld metal which is highly resistant to cracking. Particularly suitable for the welding of dissimilar steels (i.e. stainless steel to mild steel) where heat treatments are applicable. For hardfacing DW RSP may be used as a buffer layer. Excellent weldability with a spatter free arc, self-releasing slag combined with a very smooth bead appearance. Efficiency 100%. Packed in Gaspack system.

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Ferrite
0.02	0.9	0.8	≤ 0.03	≤ 0.02	19	10	3	5-20

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				20 °C
As Welded	≥ 580	680 - 780	≥ 26	≥ 60

Materials

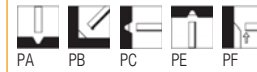
Dissimilar joints

Storage

Keep dry and avoid condensation.
If necessary Re-dry at 350-370 °C for 1 hour, 3 times max

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CAN	
				PC	Code
2.0	300	30-50	11.5	310	ETC PH-RSP20
2.5	300	45-75	18.4	190	ETC PH-RSP25
3.2	350	60-120	35.0	120	ETC PH-RSP32
4.0	350	90-140	51.3	80	ETC PH-RSP40
5.0	350	130-180	84.0	50	-

