

GOLD 210-E

FOR WELDING LOW ALLOY STEELS

Description and Applications:

Universal rutile type electrode to weld in all positions including vertical down.

Wide range of applications on all types of low carbon-steels. For general use in construction welding, **chassis, tubular connections, pipe welding, boilers, ducts, tanks, air con units, machine guards, sheet metal.....**

Easy striking, welds through grease, oil and rust, ideal for short welds, root runs and tack welds,

All position, contact type welding possible

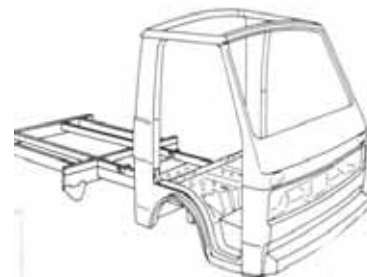
For thin gauge material where distortion must be kept to minimum.

Base material: ASTM A285 grade C,A, A442 grade 55,60

Ship steels quality A and B

EN Steels S 185-S355, P235-P355

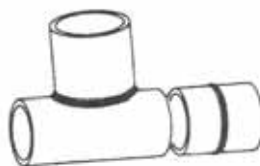
Weld metal composition: C, Si, Mn, Fe



Vehicle chassis



Machine construction



Tubes and pipes



Containers and tanks

Technical data: Up to :

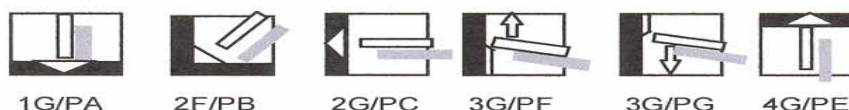
Rm (MPa)	Re (MPa)	A5 (%)
580	400	22

Packaging Data

Sizes	2.0x300	2.5x350	3.2x350	4.0x450
Kgs / Packet	4	4,5	4,5	5,5
Packets/ carton	4	4	4	4
Kgs / carton	16	18	18	22

Current (A) DC(-) AC OCV 50 V	60	80	120	150
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Welding positions



Clean weld area. Use AC or DC welding machine. Tack weld parts to be joined

Select lowest amperage as per recommendations in table.

Hold electrode slightly inclined in direction Of travel. Do not weave when contact welding.