

GOLD 220-E

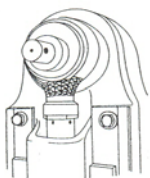
FOR MILD AND LOW ALLOY STEELS

Description and Applications:

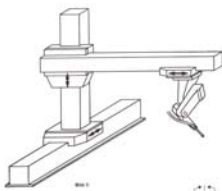
Super high strength low hydrogen Electrode **for repair and fabrication of carbon and carbon manganese steels** when **high mechanical properties** are required, i.e. on highly restrained joints like for bridges, earthmoving equipment, heavy duty vehicle bodies, cranes, ships, kilns, rams, columns, forging equipment.....

Exceptional welding characteristics and high impact values.

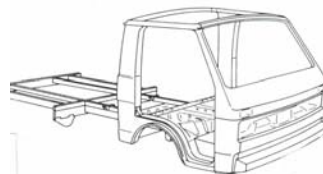
Use on mild steel cast steel, fine grained steel and steels high in sulphur, tube steels, steels for boiler and pressure vessels, high strength steel, cold tough steels.



Repair cracked machine bases



Fabricate columns and construction



Repair and fabrication of trucks

Mechanical properties

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

Welding recommendations

Current (A) DC(+) AC OCV 70	60	80	120	150
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Welding positions

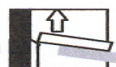
1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

Clean weld area. remove cracked or fatigue metal by grinding or chamfering with gold 110.
Preheat heavy sections. Weld with short arc. Apply stringer beads.
chip of slag between passes and peen weld areas.

For Large assemblies and for forging equipment stress relieving at 550-600 °C for one hour per 25 mm Job thickness is recommended