

OG 1

Oxy-Acetylene Welding Rod - Non Alloyed Steels

Standards

AWS/ASME SFA - 5.2	R45
EN 12536	O1
TS 3623 EN 12536	O1

Properties and Applications

Low carbon steel welding rod for oxy-acetylene welding. It is a general purpose rod for welding low carbon steels and wrought iron with the required tensile strength does not exceed 310 N/mm². Generally used for automotive repair works like tears and rips in the body or patching on badly damaged parts, joining steel sheets and plates, tubing and piping installation where and intense heat source is required for straightening, forming, preheating post weld heat treatment, regardless of the complexity and position in which welding has to be done. Weld metal has got good ductility and machinability. Welding shall be performed in neutral flame characteristics. It has got a fluid weld puddle.

Materials

Width	DIN
P235TR1 - P275T1	St 37.0 - St 44.0
S235J2	St 37.3
S235JR	St 37.2

Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn
Weld Deposit	0.05	0.05	0,50

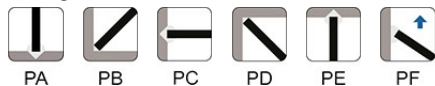
Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	Oxy-Fuel	280	450	20	20°C → 50

* Chemical composition and mechanical properties are valid when using shielding gas .

Application Information

Welding Positions



Welding Parameters & Efficiency

Diameter x Length (mm)
1.60x1000
2.00x1000
2.40x1000
3.20x1000
4.00x1000
5.00x1000

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
21160GBKM2	1.60x1000	5 kg	5.30	4	21.40	Cardboard Tube
21160HBKM2	2.00x1000	5 kg	5.20	1	5.20	Cardboard Tube
21160IBKM2	2.40x1000	5 kg	5.20	1	5.20	Cardboard Tube
21160LBKM2	3.20x1000	5 kg	5.20	1	5.20	Cardboard Tube
21160MBKM2	4.00x1000	5 kg	5.20	1	5.20	Cardboard Tube
21160NBKM2	5.00x1000	5 kg	5.30	4	21.40	Cardboard Tube

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.