

## OG 2

### Oxy-Acetylene Welding Rod - Non Alloyed Steels

#### Standards

AWS/ASME SFA - 5.2	R60
EN 12536	O II
TS 3623 EN 12536	O II

#### Properties and Applications

Low carbon steel welding rod, for oxy-acetylene gas welding, containing slightly higher manganese. It is a general purpose welding rod with medium strength, used for welding carbon steels and low alloy steels with tensile strengths up to 410 N/mm<sup>2</sup>. Commonly used for carbon steel pipe installation and repair works in power plants, process piping, machine and agricultural tool repair, joining steel plates and wrought irons, filling holes and edged on wrought iron, where an 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. Welding shall be performed in neutral flame characteristics. It has got a fluid weld puddle.

#### Materials

Width	DIN
S235J2	St 37.3
P235TR2	St 37.4
P235GH- P265GH	H I, H II

#### Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn
Weld Deposit	0.10	0.30	1.00

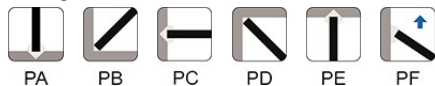
#### Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	Oxy-Fuel	300	440	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

#### 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
21161GBKM2	1.60x1000	5 kg	5.20	4	5.20	Cardboard Tube
21161HBKM2	2.00x1000	5 kg	5.20	4	5.20	Cardboard Tube
21161IBKM2	2.40x1000	5 kg	5.20	4	5.20	Cardboard Tube
21161LBKM2	3.20x1000	5 kg	5.20	4	5.20	Cardboard Tube
21161MBKM2	4.00x1000	5 kg	5.20	4	5.20	Cardboard Tube

#### Storage & Re-Drying Information

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