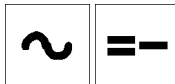


Coating type:
Rutile

Current:



Welding positions:



Velora is our “slow freezing” rutile coated electrode for all welding positions, except vertical down position. The electrode is characterised by easy handling, smooth arc transfer, easy slag removal and a finely rippled bead surface. Velora is selected for fast downhand welding of thin sheet metals (< 5,0 mm. wall-thickness). Typical applications include assembly, workshop and repair welding of mild and low-alloyed structural steels. Velora is an all-current type (AC/DC), which also operates on transformers with low OCV, min. 42V.

Base materials to be welded:

- Ships plate A-D, A(H)32-D(H)36, S315G1S-S355G3S
- Structural steel S185-S355J2, St.33-St.52, C(K)10-C(K)35
- Boiler steel P235GH-P295GH, HI, HII, 17Mn4
- Fine grain steel P275N-P355N, S275N-S355M, StE285-StE 355, StE285-StE355TM
- Pipe steel P235T1-P355N, L210-L360NB, St37.0-St52, St45.8, X42-X52, StE210.7-StE360.7TM
- Cast steel GP240R, GS45

Applications:

- Shipbuilding & Offshore
- General fabrication & construction
- Power Generation
- Repair & Maintenance

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P
0,10	0,5	0,3	0,006	0,018

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 420	≥ 510	≥ 22	0°C ≥ 47 20°C ≥ 60

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	20,5	60-100
3,2	350	34,4	100-140
4,0	450	70,0	150-190