

The product data sheets of the individual HILCO Welding Consumables contain a detailed description of each respective product. The data sheets are subdivided as follows:

## Product identification

Brand name: mentioning the typical name of the respective product

Product ID: in sequence process - steel grade - typical application (optional)

Standard designation: classification according to AWS/ASME (Section II part C), EN and EN Werkstoffnr.

## Typical characteristics of the product

Gives information about the specific product, the product properties and our recommendations for welding current, polarity, welding positions, approvals and arc voltage which is the voltage at which you can strike the arc of the stick electrodes. The different welding positions which according to AWS and EN are indicated by code digits are symbolized in the product data sheet as follows:



**AWS:** 1G, 2G, 3G, 4G, 5G, 6G  
**EN:** PA, PB, PC, PD, PE, PF, PG  
 "All positions"



**AWS:** 1G, 2G, 3G, 4G, 5Gu  
**EN:** PA, PB, PC, PD, PE, PF  
 "All positions, except vertical down"



**AWS:** 1G, 1F, 2G, 2F  
**EN:** PA, PB, PC  
 "Flat butt and fillet welds only"

## Application / properties

A description of the typical characteristics of the specific product, the most important base materials to be welded and its typical applications. In case the base material or application requested is not included in the data-sheet, or if you have any questions on the subject, your local HILCO distributor or our office in the Netherlands will be pleased to help you. You can call us at the number of HILCO in the Netherlands +31 - (0) 23 - 531 91 00.

Fax +31 - (0) 23 - 532 59 06

Email: [info@hilco-welding.com](mailto:info@hilco-welding.com)

## Chemical composition

The weld metal analysis indicates the chemical composition of the deposit weld metal in weight % per element. The values indicated in the product data sheets were determined by routine testing by our quality assurance department.

## Mechanical properties

The specified mechanical properties are typical values and refer to all-weld metal. It must be taken into account that the mechanical properties of welded joints, depending on the base materials, dimensions of the component, welding position, welding parameters, preheating, interpass temperatures, post-weld-heat-treatment (PWHT), may deviate from those of the all-weld metal. The mechanical properties indicated in the product data-sheets are to be considered as general guidelines and they may vary according to the variations of product batches.

## Disclaimer

The products and information in this handbook are based on today's knowledge about welding, welding techniques and product development. All technical data mentioned is not binding and alterations are possible at any time. If necessary, please contact us for the latest developments.

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