

R-26

EN ISO 2560-A-E 35 0 RA 1 2
JIS Z 3211 E4340

Characteristics and Applications:

R-26 is suitable for butt or fillet welding of mild steel. The weld metal has good crack resistance, good tensile strength, good slag detach ability, less spatters and excellent toughness. Its features make the product being applied to important structural objects such as ship body, boiler, vehicle frame, oil tank, steel frame and suitable for structural steels, steel strip, thin steel plate, fabrication steels which thickness is 16 mm or less.

Notes on usage:

1. Be sure to clean up the contaminations on the base metal.
2. It is highly recommended to dry the electrodes at 80-100 °C for 30-60 minutes before using.
3. Apply proper currents for good X-Ray and mechanical properties.
4. The moving range should not exceed 3 times the wire dia when you are welding with weave method.

Typical chemical composition of weld metal (wt%):

| C | Mn | Si | P | S |
|------|------|------|-------|------|
| 0.08 | 0.32 | 0.20 | 0.022 | 0.01 |

Typical mechanical properties of weld metal:

| Yield strength MPa(ksi) | Tensile strength MPa(ksi) | Elongation % | Charpy V-Notch J (ft-lbf) 0°C (32 °F) |
|----------------------------|------------------------------|-----------------|---|
| 430(62) | 490(71) | 25 | 65(48) |

Welding position:



Sizes and recommended current range (AC or DC +)::

| Diameter (mm) | | 3.2 | 4.0 | 5.0 |
|---------------|------|--------|---------|---------|
| Length (mm) | | 350 | 450 | 450 |
| Amps | F | 80-130 | 120-180 | 170-240 |
| | V&OH | 60-110 | 110-160 | 130-180 |

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