

Classifications

DIN 2302

E 42 0 Z R 2 fr (PB, PC, PD, PG)

Characteristics and typical fields of application

Stick electrode with excellent welding seams for manual welding in wet environments and for economical, qualified wet underwater welding joints.

Proven welding through a TÜV test in a water depth of 2 m.

The electrode can be used up to 20 m water depth.

Base materials

S235JR – unalloyed and fine grained structural steels. Higher strength structural steels should not be welded with this type of electrodes as these materials are susceptible to "Hydrogen Induced Cold Cracking (HICC)" when welded in wet environment. The carbon content of the parent metal should not exceed 0.15 %.

Typical analysis

	C	Si	Mn	Mo
wt.-%	0.08	0.3	0.55	0.5

Mechanical properties of all-weld metal - typical values (min. values)

Yield strength $R_{p0.2}$	Tensile strength R_m	Impact energy ISO-V KV J
MPa	MPa	
≥ 420	500	38

Heat treatment: AW

Operating data

	Polarity	DC + / DC -	Dimension mm	Current A
				3.2 x 350

Underwater welding with UTP Nautica 20 should be performed with min. 3 weld beads.

Approvals

TÜV (acc. DIN 2302-1001.00)