

## Classifications

### DIN 2302

E 42 0 Z R 10 fr (PB, PD, PG)

## Characteristics and typical fields of application

Covered electrode for manual metal arc welding under hyperbaric wet conditions down to 20 msw. Very good weldability in vertical down position.

## 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	150 – 200

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

## Approvals

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