PHOENIX SPEZIAL D

Double-coated basic stick electrode

Main benefit

Double coated electrode both for welding on site and in the shop.

Product features	Product benefits	User benefits
» **Double coated electrode**	» Good gap bridging ability	» Easy welding on site even with different gaps
» **Easy handling in all position**	» Stabel arc, very good welding characteristics	» Fast welding, less preparation leads to high productivity
» **Approved for root pass**	» Full slag cover on both sides of the root	» Save root runs with high productivity
» **Available in Dry System vacuum packs**	» Welding directly out of the package without re-drying	» Less time for preparation, always safe packed, fresh stick electrodes

Typical applications

» Steel constructioin
» Mounting of several steel parts
» Container or tank construction
» For industrie as well as for handicraft

The double-coating of the Phoenix Spezial D is pressed onto the core wire in 2 steps. The result is a very homogeneous coating that guarantees constant welding properties and mechanical properties. This coating concept enables constant centricity, good wetting behavior and gap bridging. This good bridging properties offers reliable root welding, especially during assembly work with irregular gap dimensions.

PHOENIX SPEZIAL D

Classifications		Operating data	
EN ISO 2560-A	AWS A5.1 / SFA-5.1	Welding positions	Polarity
E 42 3 B 1 2 H10	E7016		

Typical analysis of all weld metal, wt. %		
C	Si	Mn
0.06	0.65	1.05

Mechanical properties, all weld metal (single values typical)					
Condition	Yield strength $R_{p0.2\%}$ MPa	Tensile strength R_m MPa	Elongation $A (L_0 = 5d_0)$ %	CVN Impact toughness ISO-V KV J 20 °C	-30 °C
Untreated, as welded	440 (>= 420)	550 (500 – 640)	28 (≥ 20)	170	50 (≥ 47)

Steels to be welded	
EN	ASTM
Steels up to a yield strength of 420 MPa (60 ksi) S235JR-S355JR, S235JO-S355JO, S235J2-S355J2, S275N-S420N, S275M-S420M, P235GH-P355GH, P355N, P285NH-P420NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L245MB-L415MB, GE200-GE240	ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. A, C, D; A 662 Gr. A, B, C; A 678 Gr. A, B; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X56, X60

Approvals
TÜV (10572), DB (10.138.12), LR, DNV, CE

Carton Packaging		Dry System Vacuum Packaging	
	Weight: ~ 4.1 kg Diameter: 2.5 x 350 mm 3.2 x 350 mm 3.2 x 450 mm 4.0 x 450 mm 5.0 x 450 mm		Weight: DrySys 20: ~1.2 kg DrySys 30: ~ 2.1 kg Diameter: 2.5 x 350 mm 3.2 x 350 mm 3.2 x 450 mm 4.0 x 450 mm 5.0 x 450 mm