

Electrode OZS-12



Type E46

Electrodes brand OZS-12 are designed for manual arc welding of structural carbon steel with carbon to 0.25% when the shape of stitches in different spatial positions make demands. Welding in all-dimensional position than vertical top-down, direct current reverse polarity and variable currents of power supply with a voltage idling (50 ± 5) B.

The recommended value of current (A)

Diameter, mm	seam position		
	lower	vertical	ceiling
2,5	70-90	60-100	60-100
3,0	100-140	80-100	80-100
4,0	160-220	140-180	140-180
5,0	170-260	160-200	-

Melting electrodes

- Coefficient of surfacing, g / Ah: 8,0-8,5
- Depletion of electrodes at 1 kg surfaced metal kg: 1.7

The main characteristics of the metal and weld metal surfaced

The mechanical properties of metal weld, not less

- Temporary breaking strength, MPa: 460
- Relative elongation, %: 20
- Impact strength, J / cm²: 80

Chemical composition surfaced metal%

- Carbon, no more: 0.12
- Manganese: 0,35-0,70
- Silicon: 0,09-0,25
- Sulfur, no more: 0,040
- Phosphorus, no more: 0,045

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GOST 9467-75
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