

## Iron Powder Coated Electrode for Mild Steels

### Classification

EN ISO 2560-A : E 46 0 RR 74  
AWS A5.1 : E7024

### General Description

AS DT-165 is a heavily coated, high efficiency rutile iron powder electrode. It gives a metal recovery of about 165 % due to high iron powder content in its coating. It is particularly suitable for fillet welding of thick plates. It gives smooth weld bead appearance with a soft arc. The slag is easy to remove.

### Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn
0.08	0.40	0.70

### Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 500 N/mm <sup>2</sup>
Tensile Strength	: 580 N/mm <sup>2</sup>
Elongation (L=5d)	: 24 %
Impact (ISO-V)	: 60 J (0°C)

### Approvals

CE, GOST, SEPRO, TSE

ABS	BV	RINA	TL
2	2	2	2

### Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : AC min 70 V ; DC (-)

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
3.25	450	130 - 155	6540	5.9 / 90	6
4.00	450	170 - 240	10050	6.0 / 60	6
5.00	450	250 - 310	14920	6.0 / 40	6



1G/PA



2F/PB

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### Applications and Materials to be Welded

It is used for the welding of medium carbon and mild steels. AS DT-165 is an ideal electrode particularly used for welding vertical-horizontal fillets. Weld metal goes well up the vertical plate giving a good transition to the base metal without undercutting, even at high currents.

Machinery fabrication and ship building where smooth weld beads are required; boiler and pressure vessel manufacturing; automotive bodies and steel and bridge constructions are among some application areas where AS DT-165 is extensively used as it brings high efficiency in terms of welding cost.

	<u>DIN</u>	<u>EN</u>
<b>General Structural Steels</b>	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52* C 10 - C 22	S185, S235, S275, S355 C10 - C22
<b>Fine Grained Steels</b>	StE 255 - StE 420 WStE 255 - WStE 420	S255N - S420N P255NH - P420NH
<b>Pipe Materials</b>	StE 210-7 - StE 360-7 X42, X46, X52, X60 (API 5LX)	L210 - L360NB -
<b>Boiler and Pressure Vessel Steels</b>	17 Mn 4, 19 Mn 6 H1, H11, H111	P295GH, P355GH P235GH, P265GH, P285NH
<b>Elevated Temperature Steels</b>	St 35-8, St 45-8	P235G1TH - P255G1TH
<b>Ship Plates</b>	A, B, C, D*, E* AH32 - EH36	- -
<b>Cast Steels</b>	GS-38, GS-45, GS-52*	GE200, GE240, GE260

(\*) It is recommended to use a basic coated electrode in the root pass.