

FERROCRAFT 21

PRODUCT DATA SHEET



**POPULAR RUTILE TYPE,
MEDIUM IRON POWDER
ELECTRODE**

**45
OCV**

**DC
AC**

MILD STEEL & IRON POWDER ELECTRODES

FERROCRAFT 21

- Rutile Type, Medium Iron Powder Electrode.
- Easy Striking - Hot or Cold!
- Excellent Operator Appeal!
- Ideal for Vertical Down Fillet Welding.
- Versatile - All Positional Capabilities.
- Reliable Impact Toughness to -20°C .

CLASSIFICATIONS:

ISO AS/NZS 4855:	B E4914 A U
AWS/ASME-SFA A5.1:	E7014

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	430 MPa
Tensile Strength	500 MPa
Elongation	30%
CVN Impact Values	90 J av @ -20°C

TYPICAL ALL WELD METAL ANALYSIS:

C:	0.06%
Mn:	0.65%
Si:	0.30%

DESCRIPTION AND APPLICATIONS:

Ferrocrafft 21 is a popular rutile type, medium iron powder electrode developed and manufactured in Australia by CIGWELD. It offers many features including smooth stable AC / DC running on low O.C.V. welding machines, excellent fillet shapes in all welding positions (including vertical-down/up and overhead) and a higher electrode efficiency of 110%. In addition, Ferrocrafft 21 produces good radiographic quality, a self releasing slag and improved "Grade 2" (min 47J av @ -20°C) impact properties.

Ferrocrafft 21 is suitable for workshop or 'on-site' repair, maintenance and fabrication welding jobs where the iron powder addition gives improved usability over conventional E4112 rutile type electrodes.

It is the ideal vertical-down fillet welding electrode for thinner steel sections using "Touch Welding" techniques. It produces a controllable fast freezing slag with outstanding slag lift and minimum undercut.

PACKAGING & OPERATING DATA:

AC (minimum 45 O.C.V.), DC+ or DC- polarity.

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	APPROX NO. RODS/KG	CURRENT RANGE (AMPS)	PACK SIZE	CARTON	PART NO.
2.5	350	50	60-100	4.6kg	13.8kg - 3 x 4.6kg	611242N
3.2	380	26	95-140	5kg	15kg - 3 x 5kg	611243
4.0	380	17	140-195	5kg	15kg - 3 x 5kg	611244
5.0	450	9	200-260	5kg	15kg - 3 x 5kg	611245

-5.0mm Ferrocrafft 21 is not recommended for out-of-position (ie vertical or overhead) welding applications.

WELDING POSITIONS:

All positional - welding.

