

FERROCRAFT 22

45
OCV

DC
AC

- ▲ Rutile Type High Iron Powder Electrode.
- ▲ High Productivity Fillet and Butt Welding in All Downhand Positions.
- ▲ Self Releasing Slag.

Classifications:

AS/NZS 1553.1: (old) E4824-0.
AS/NZS 4855: (new) E 4924 A
AWS/ASME-SFA A5.1: E7024

Description and Applications:

Ferrocrafft 22 is a rutile type high iron powder electrode for the higher productivity fillet and butt welding of mild steel in all downhand (flat and horizontal-vertical) positions. Slag lift and "side wall" wash at weld toes are superb and welding speeds are approximately double those of conventional electrodes of equal size and length. Ferrocrafft 22 is recommended for high production welding where large standing fillet welds are required. It is the ideal electrode for heavy structural welding applications such as tanks, frames, girders and beams, ship structures and rolling stock and general fabrication in the workshop or on-site.

APPROVALS:

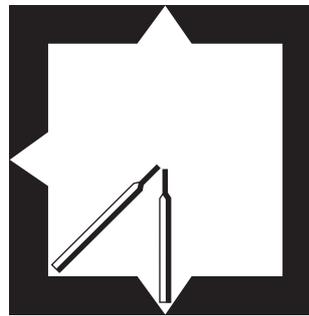
Det Norske Veritas Grade 2.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress 440 MPa
Tensile Strength 512 MPa
Elongation 25%
CVN Impact Values 60J av @ 0°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.05% Mn: 0.75% Si: 0.25%



Packaging and Operating Data:

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

Electrode	Approx No.	Current	Packet	Carton	Part No	
Size mm	Length mm	Rods/kg	Range (amps)			
3.2	380	18	130-170	5kg	15kg - 3 x 5kg	611253
4.0	450	11	185-235	5kg	15kg - 3 x 5kg	611254
5.0	450	7	260-320	5kg	15kg - 3 x 5kg	611255

- Ferrocrafft 22 is formulated to operate with AC (min 45 O.C.V.), DC+ or DC- polarity. The preferred polarity for DC fillet welding is DC+.