



P 47

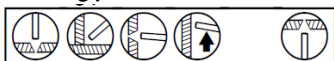
SMAW - (Stick) - MMA
Un-alloyed

Date: 2021-07-08
Revision: 26

Description:

P 47 is a basic-coated, 105% recovery electrode intended for general welding applications in those cases where a "7016" type is preferred. P 47 has very good positional operability and excellent resistance to porosity in plate coated with primer or contaminated by mill scale and rust. Suitable for shipbuilding, storage tanks and general construction purposes.

Welding positions:



Coating type:

Basic;

Welding current:

DC+/-, AC OCV ≥ 60 V

For root passes: DC-

Hydrogen content / 100 g weld metal

≤ 5 ml;

Metal recovery:

105%

Redrying temperature:

375-400 °C, 2h

Chemical composition, wt. %

	C	Si	Mn	P	S	Cr	Ni
Min		0,30	0,85				
Typical	0,06	0,5	1,1	0,015	0,005		
Max	0,09	0,70	1,25	0,030	0,015	0,1	0,2

	Mo	Cu	V	Nb
Min				
Typical				
Max	0,1	0,2	0,05	0,05

Mechanical properties

	<u>Specified</u>	<u>Typical</u>	<u>PWHT Typical</u>
Yield strength, Re:	≥460 MPa	490 MPa	420 MPa
Tensile Strength, Rm:	530-660 MPa	570 MPa	515 MPa
Elongation, A5	≥ 22%	26%	31%
Impact energy, CV:	-40 °C • ≥47 J -46 °C • ≥27 J	-46 °C • 70 J	-40 °C • 150 J 620°C x1h

Product data:

Diam.mm	Length mm	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,5	350	60-90	24	0,64	80	0,9	50
3,2	350	80-160	26	0,66	44	1,2	65
4,0	450	110-200	24	0,67	22	1,7	86

Classification:

EN ISO 2560-A E 46 4 B 12 H5
AWS A5.1 E 7016-1

Approvals:

CE
BV 3 Y HH
DNV 3Y H5
LR 3Ym H5
ABS 4YQ420 H5
MRS 4Y40 H5
NAKS

Note

Core Wire :

S ≤ 0.015%

P ≤ 0.015%

N ≤ 0.008%

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and ITW Welding AB expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the corresponding EN ISO specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by ITW Welding AB.