

R-26

JIS Z 3211 D4340

Characteristics and Applications:

R-26 is suitable for butt or fillet welding of mild steel. The weld metal has good crack resistibility, good tensile strength, good slag removability, less spatters and excellent toughness. Its features make the product being applied to important structural objects such as ship body, boiler, vehicle frame, oil tank, steel frame and suitable for structural steels, steel strip, thin steel plate, fabrication steels whose thickness is 16 mm or less.

Notes on Usage:

1. Be sure to clean up the contaminations on the base metal to reduce welding defect.
2. It is highly recommended to dry the electrodes at 80-100°C for 30-60 minutes before use.
3. Apply proper currents to prevent X-Ray and mechanical properties from being worse.
4. When welding with weave method, the moving range should not exceed 3 times the wire dia.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S
0.08	0.40	0.15	0.02	0.01

Typical mechanical properties of weld metal

YS (MPa)	TS (MPa)	EL %	CVN 0°C J
420	470	25	75

Welding position



Sizes and recommended current range (AC or DC $\langle \pm \rangle$)

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	450	450
Amps	F	80-130	120-180	170-240
	V&OH	60-110	110-160	130-200

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