



**OERLIKON**

[www.oerlikon-welding.com](http://www.oerlikon-welding.com)

**SPEZIAL**  
THE ONLY TRUE DOUBLE COATING

# UNDERSTANDING DOUBLE-COATED TECHNOLOGY

## WHAT IS DOUBLE COATING

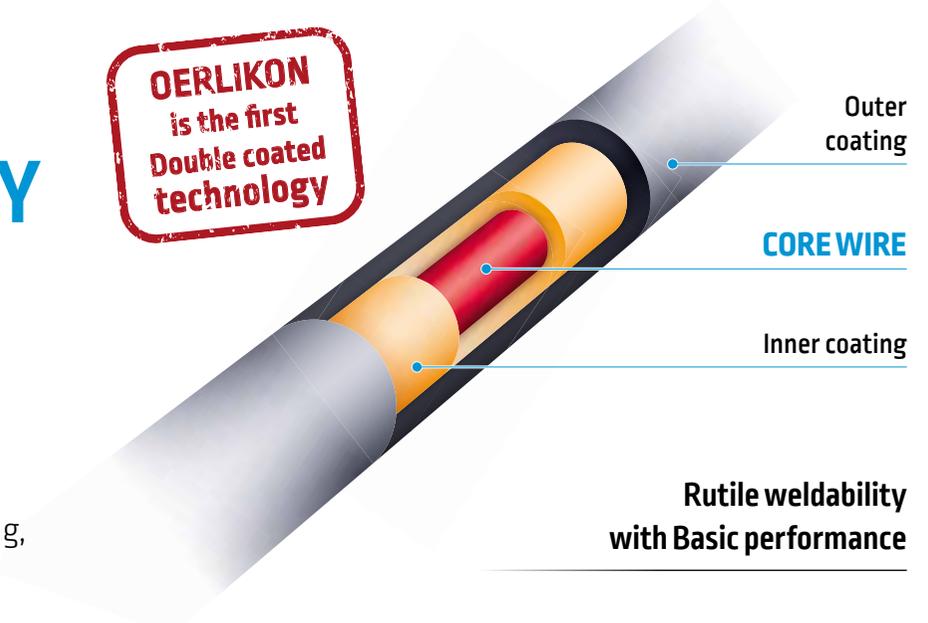
A double-coated electrode consists of two separate layers:

- The “outer layer” with higher basicity
- The “inner layer” rutil-acid

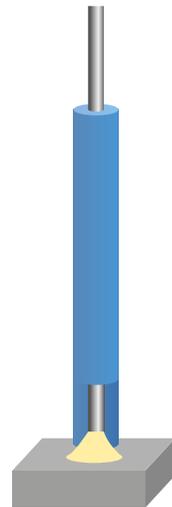
The arc-stabilizing minerals and metal powders are concentrated in the inner coating, and the minerals delivering the gas shielding are concentrated in the outer coating.

This combination enables unique weldability characteristics.

**OERLIKON**  
is the first  
Double coated  
technology

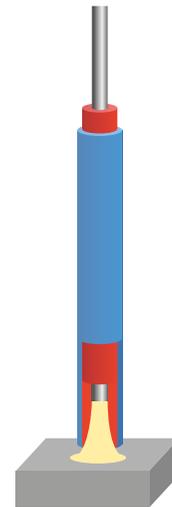


**Basic single coated electrode**



Less concentrated arc

**Double coated electrode**



Easier to control, more concentrated, rigid arc

## ADVANTAGES

### CHARACTERISTIC

- Extremely stable arc
- Easy weld pool control
- Insensitive to the effects of arc blow
- Excellent weldability in Vertical Up
- Easy slag removal
- Excellent arc striking
- Few spatters, no sticking
- Smooth bead appearance
- More concentrated arc
- High arc force
- High stability at very low welding current setting

### CUSTOMER BENEFITS

- Easy to be used, even for beginners
- Reduced post-welding reworking
- Ideal for root passes even with poor joint preparation and irregular gaps
- Deeper penetration
- Reduced risks of lack of fusion
- Wider array of equipment can be used
- Stability at low amperage when welding with low heat inputs

# SPEZIAL<sup>®</sup> multi-purpose MILD STEEL STICK ELECTRODE

Extremely flexible Mild Steels applications [S(P) 235; S(P) 355; GP 240; GP 280; L 245 and L 260] from structural steelwork to piping. The composition of double coating allows for exceptional weldability. Particularly suitable for root passes: highly stable and directional arc facilitates high gaps bridging and irregular gaps welding in Vertical up position.

- Very stable arc, insensitive to the effects of arc blow
- High penetration
- Excellent operator appeal
- Exceptional wetting even at low amperages
- High flexibility for irregular gaps



Double coating provides more stable and directed arc, making the electrodes particularly suitable in challenging cases, such as bad preparation, misalignment, or big gaps between plates or pipes.



For more information see this video



## Ordering information

Ø (mm)	AWS A 5.1	ISO 2560-A	Length (mm)	Cardboard box		VPMD	
				Qty Per pack	Reference	Qty Per pack	Reference
2.0	E7016-H8	E 38 3 B 12 H10	350	330	W000287401	160	W000287407
2.5			350	200	W000287402	100	W000287408
3.2			350	125	W000287403	55	W000287409
3.2			450	125	W000287404	55	W000287410
4.0			450	80	W000287405	40	W000287411
5.0			450	50	W000287406	-	-



#### **CUSTOMER ASSISTANCE POLICY**

The business of Lincoln Electric is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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