RAILROD

TOP FEATURES

- MMA electrode for rail welding
- Recovery is about 110%
- Good side wall fusion and low slag interference

TYPICAL APPLICATIONS

- Rails for rolling stock
- Crane rails in dockyards, mines, steelworks and petrochemical plants

CLASSIFICATION

None strictly applicable, nearest AWS E12016-G and nearest E69 Z Z B.

CURRENT TYPE

DC+/AC

WELDING POSITIONS

downhand and horizontal

CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo
Min.	0.06	0.7	0.2	not specified	not specified	2.0	not specified	not specified
Max.	0.12	1.5	0.8	0.020	0.025	2.6	0.5	0.5
Typical	0.09	1	0.5	0.008	0.012	2.3	0.2	0.2

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

PWHT 610-650°C/1-6h		Typical
Tensile strength	**(MPa)**	900
0.2% Proof strength	**(MPa)**	700
Elongation (%)	**4d**	17
Impact ISO-V (J)	**- 20°C**	18-48
	- 40°C	14-43
Hardness (HV)		280

* For comparison, typical thermit rail weld: 8J @ 20°C, 5J @ 0°C.

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
5.0 x 450	200-280

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
5.0 x 450	CAN	57	5.5	RR-50-1

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.