

DESCRIPTION:

The WELDWELL PH68 is a medium-heavy-coated rutile electrode which produces very rapidly solidifying slag. It is an outstanding electrode for welding in all positions and at places difficult to reach. An important feature is that the **same current can be used for welding in any position.**

This means that welding can be done without repeated setting of the current, and accordingly a considerable saving in time is obtained.

PH68 is suitable for **vertical down welding** because of the excellent slag control.

Applications:

The PH68 is suitable for welding in sharply curved and poorly fitting grooves, as well as inclined grooves. It melts off in fairly coarse droplets, for which reason it is used for bridging large gaps. The very rapidly solidifying slag prevents the liquid weld metal from flowing away when welding is done in difficult positions, especially pipe welding.

Welding Techniques

Before welding commences, the current setting should be checked to see that it is correct for the type of work. If the current is too low, the metal tends to pile and the bead will be lumpy and irregular. If the current is too high, a flat deposit with undue spatter and wastage of the electrode will result.

Different applications require variations within the recommended current range and with PH68 a current setting is possible to allow welding in all positions without having to alter it. In general, a medium arc length is used to gain even welds but touch welding is possible at currents near to maximum.

In vertical positions, extremely heavy deposits of mitre contour can be made in one pass for butt and fillet welds using a triangular weaving motion. For second and subsequent passes, only a simple side to side weave is required with a slight pause in each corner to avoid undercutting.

When used with DC it is normally connected to the negative (-) pole.

Recommended Amperages

Dia. mm	Length mm	Amperes	Deposition Rate kg/hr*
2.5	305	60-95	
3.2	380	70-125	1.20
4.0	380	130-170	1.68
5.0	455	170-240	2.22

* Deposition rate at maximum amps.

AC 50V DC -

The type PH68 is highly recommended to weld Galvanised Steel.

AWS A5.1:2004 : E6013
AS/NZS 4855B:2007 : E4313A

WELDWELL



ELECTRODES FOR WELDING MILD STEEL

TIP COLOUR Red
FLUX MARKING PH68 6013 4313A

Approvals:

American Bureau of Shipping
Lloyds Register of Shipping
Bureau Veritas

Welding Positions:

F, H, V, VD, OH

Typical Mechanical Properties of Weld Metal

Tensile Strength	495 MPa
Yield Value	443 MPa
Elongation(1 = 5d)	29%
Impact Value Charpy	
V Notch at 20°C	87 J

Typical Chemical Analysis

C	0.06%
Mn	0.43%
Si	0.46%

Storage

Store electrodes in a dry place. To recondition moist electrodes bake for half an hour at 120°C in a vented oven.