

TALARC 86TC

CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.1: E7016	EN ISO 2560-A: E 42 2 RB 32

ALLOY TYPE

Rutile-basic-coated electrode for welding carbon and C-Mn steels.

APPLICATIONS

Special double-coated (rutile – basic) electrode to be used for the welding of carbon and carbon-manganese steels with tensile strength up to 510 MPa. Particularly designed for both A.C. and D.C. welding, it is suitable for maintenance works and for welding dirty parts. Excellent weld bead and rather brittle, easily removable slag, very limited spattering. Hygroscopic coating.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

C %	Mn %	Si %	S %	P %	Cu %	Ni %	Cr %	Mo %
0.07	1.00	0.40	0.025	0.025	-	-	-	-

TYPICAL MECHANICAL PROPERTIES

	Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
	Rs	Rm	A 5d	0°C	-20°C	-30°C	-40°C	-60°C
	(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
as welded	470	540	26	-	70	-	-	-

WELDING GUIDELINES

Preheat dependent on steel type and PWHT not usually required. Vacuum packed electrodes can be used directly from pack without pre-conditioning and need to be placed immediately into quiver or hot box. Once exposed, electrodes are to be reconditioned at 370÷400°C for an hour (max 3 times).

TECHNICAL INFORMATION

Welding positions: all positions, except vertical down



WELDING PARAMETERS

Current	AC / DC - (+) Straight polarity		
Diameter (mm)	2.5	3.2	4.0
Length (mm)	350	350	450
Current (A)	60 ÷ 110	90 ÷ 140	130 ÷ 190

Diam.	Pack/Carton	Part No.
2.5mm	2kg VAC pack/12kg	INE8625
3.2mm	2kg VAC pack/12kg	INE8632
4.0mm	1.8kg VAC pack/10.8kg	INE8640

TALARC Pty Ltd
10-16 Syme St
Brunswick, Vic 3056
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710
W: www.talarc.com E: sales@talarc.com