

Pawel Product Specifications

Standard & Typical Chemical Composition of Deposited Metal(%)											Standard & Typical Propertise of Deposited Metal(%)				
C	Mn	Si	S	P	Cr	Ni	Fe	Mo	Cu	V	Yeild Point (6s Mpa)	Tensile Strenght (6s Mpb)	Elongation (δ 5,%)	Akv Value (J)	
Mild Steel Electrodes															
Pawel China		Rutile Coated					AWS/ASME SFA- 5.1 E6013					H,VU,VD,OH		AC or DC (pole-)	
0.08	0.50	0.30	< 0.02	< 0.02	-	-	-	-	-	-	>360 N/mm ²	450-550N/mm ²	>22%	20°C > 60 0°C > 50 -20°C > 25	
Pawel E-6013		Rutile-acid					AWS/ASME SFA- 5.1/E6013/6020					H, VU, OH		AC or DC (pole-)	
0.08	0.70	0.20	< 0.02	< 0.02	-	-	-	-	-	-	>360 N/mm ²	450-550N/mm ²	>24%	20°C > 80 0°C > 70 -20°C > 50 -40°C > 25	
Pawel Citobest		Rutile-cellulosic,light coated					AWS/ASME SFA- 5.1 E6013					H,VU,VD,OH		AC or DC (pole-)	
0.08	0.50	0.30	< 0.02	< 0.02	-	-	-	-	-	-	>360 N/mm ²	450-550N/mm ²	>22%	20°C > 60 0°C > 50 -20°C > 25	
Pawel Overcord S		Rutile cellulosic,medium-coated					AWS/ASME SFA- 5.1 E6013					H, VU, OH		AC or DC (pole-)	
0.08	0.50	0.35	<0.02	<0.02	-	-	-	-	-	-	>360 N/mm ²	450-550N/mm ²	>22%	20°C > 60 0°C > 40 -20°C > 25	
Mild Steel Special Electrodes															
Pawel Ferrocito		Rutile heavy coated, iron powder					AWS/ASME SFA- 5.1 E 7024					H,F		AC or DC (pole-)	
0.08	0.60	0.35	< 0.02	< 0.02	-	-	-	-	-	-	>380 N/mm ²	510-610 N/mm ²	>24%	20°C > 60 0°C > 50 -20°C > 30	

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Cast Iron (Machinable) Electrodes															
Pawel Nife-55		Special Coating					AWS/ASME SFA- 5.15 E NiFe- C1					H, VU, OH		AC or DC (pole+)	
-	-	-	-	-	-	53	43	-	2	-	-	>450 N/mm ²	-	-	
Pawel Super Ni 99		Special Coating					AWS/ASME SFA- 5.15 E Ni- C1					H, VU, OH		AC or DC (pole+)	
-	-	-	-	-	-	98	-	-	-	-	-	>300 N/mm ²	-	-	
Electrodes For Buffer Layer															
Citocromax-N		Basic					AWS/ASME SFA- 5.4 E307-15					H,VU, OH		DC (pole+)	
< 0.12	6.0	-	-	-	19	9	-	-	-	-	>350 N/mm ²	590-690N/mm ²	>40%	20°C> 100	
Pawel 4370		Rutile contains alloying elements					AWS/ASME SFA- 5.4 E 309 MO-16					H, F		AC or DC (pole+)	
< 0.06	1.00	0.60	-	-	< 22.0	12	-	3	-	-	>400 N/mm ²	550-650N/mm ²	>30%	20°C> 40J	

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Mechanical properties of all-weld metal (typical values)

C	Mn	Si	S	P	Cr	Ni	Fe	Mo	Cu	V
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Hard Facing (Non-Machinable) Electrodes

Pawel Mangan

Basic

AWS/ASME SFA-5.13 E Fe Mn

H, F

DC (pole+)

0.70

13.00

0.30

-

-

-

-

-

-

-

-

Vickers hardness HV 30: 550-700 (180-200 HRC) (as welded condition)

Pawel Rail III

Basic

DIN 8555 E 6-UM-60

H, VU, OH

DC (pole+)

0.50

0.30

0.40

-

-

6.5

-

-

0.5

-

0.5

Vickers hardness HV 30: 670-770 (57-62 HRC) (as welded condition)

Pawel 80 R

Rutile

DIN 8555 E 6-UM-60

H, VU, OH

DC (pole+)

0.50

0.30

0.40

-

-

7

-

-

0.5

-

0.5

Vickers hardness HV 30: 670-770 (57-62 HRC) (as welded condition)

Pawel V1000

Heavy rutile type

DIN 8555 E 10-UM-60-R

H,F

AC or DC (pole+)

4.30

-

-

-

-

35

-

-

-

-

-

Vickers hardness HV 30: 680-770 (57-62 HRC) (as welded condition)

Hard Facing (Machinable) Electrodes

Pawel Dur 350

Basic

DIN 8555 E 1-UM-300

H,VU,OH

DC (pole+)

0.08

0.60

0.70

-

-

3.2

-

-

-

-

-

Vickers hardness HV 30: 280-300 (as welded condition)