



# P 47

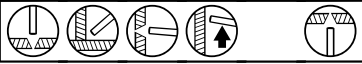
SMAW - (Stick) - MMA  
Un-alloyed

Date:	2013-05-30
Revision:	25

### Description:

P 47 is a basic-coated, 105% recovery electrode intended for general welding applications in those cases where a "7016" type is preferred. P 47 has very good positional operability and excellent resistance to porosity in plate coated with primer or contaminated by mill scale and rust. Suitable for shipbuilding, storage tanks and general construction purposes.

### Welding positions:



### Coating type:

Basic;

### Welding current:

DC+/-, AC OCV ≥ 60 V

For root passes: DC-

### Hydrogen content / 100 g weld metal

≤ 5 ml;

### Metal recovery:

105%

### Redrying temperature:

375-400 °C, 2h

### Chemical composition, wt. %

	C	Si	Mn	P	S	Cr	Ni
Min		0,30	0,85				
Typical	0,06	0,5	1,1	0,015	0,005		
Max	0,09	0,70	1,25	0,030	0,015	0,1	0,2

	Mo	Cu	V	Nb
Min				
Typical				
Max	0,1	0,2	0,05	0,05

### Mechanical properties

	<u>Specified</u>	<u>Typical</u>	<u>PWHT Typical</u>
Yield strength, Re:	≥460 MPa	490 MPa	420 MPa
Tensile Strength, Rm:	530-640 MPa	570 MPa	515 MPa
Elongation, A5	≥ 22%	26%	31%
Impact energy, CV:	-40 °C • ≥47 J -46 °C • ≥27 J	-46 °C • 70 J	-40 °C • 150 J 620°C x1h

### Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,5	350	71472533	60-90	24	0,64	80	0,9	50
3,2	350	71473233	80-160	26	0,66	44	1,2	65
4,0	350	71474033	110-210	25	0,66	29	1,7	70
4,0	450	71474045	110-200	24	0,67	22	1,7	86

### Classification:

EN ISO 2560-A  
AWS A5.1

E 46 4 B 12 H5  
E 7016-1

### Approvals:

CE	
BV	3, 3 Y HH
DNV	3Y H5
GL	3Y H5
LR	3m, 3Ym H5
ABS	4YQ420
MRS	4Y40 H5
NAKS	

### Note

Core wire: S ≤ 0.015% P ≤ 0.015% N ≤ 0.008%
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