

ASKAYNAK

Welding Technology



World's Largest Manufacturer of Welding Consumables.



ASKAYNAK WELDING ELECTRODE (AS R-143)

AS R-143 is a heavily coated rutile electrode. As its basic component quantity is higher than AS R-116, weld metal properties are superior accordingly. Weld metal has a high resistance to cracking. The slag is easy to remove, and it gives high quality, smooth and excellent weld beads. It is easy to strike and re-strike and thus an ideal, easy to use electrode

Classification & Typical Weld Metal Composition

AWS A5.1 :E6013
EN ISO 2560-A :E 42 0 RR 12

C	Si	Mn
0,08	0,35	0,65

Welding Parameters / Packing & Diameter Informations

Current Type & Polarity : AC min. 50v / DC (-)

Diameter (mm)	Length (mm)	Current (Amper)	Electrode Weight (kg/box)	Quantity
2.50	350	65 - 90	5	5
3.25	350	90 - 140	5	5



ASKAYNAK WELDING ELECTRODE (AS B-248)

AS B-248 is a basic coated electrode. It is used particularly to weld rigidly restrained mass structures where high welding stresses are unavoidable. Weld metal has a high resistance to cracking. The slag is easy to remove and it gives excellent quality, smooth weld beads. It is also suitable for welding in vertical upwards position at a high welding speed. It has 125% metal recovery.

Classification & Typical Weld Metal Composition

AWS A5.1 :E7018
EN ISO 2560-A :E 42 3 B 42 H10

C	Si	Mn
0,07	0,50	0,90

Welding Parameters / Packing & Diameter Informations

Current Type & Polarity : AC min. 50v / DC (-)

Diameter (mm)	Length (mm)	Current (Amper)	Electrode Weight (kg/box)	Quantity
2.50	350	80 - 110	5	5
3.25	350	110 - 145	5	5



ASKAYNAK MIG WELDING WIRE (AS SG2)

The new generation AS SG2 Extra non-copper coated GMA welding wires offer significant improvements in quality and productivity, meaning that users can reduce the cost of manual, mechanised or especially robotic (full automatic) welding operations. Due to its non-copper coated and improved quality wire surface, AS SG2 Extra avoids the contamination problems associated with copper coatings such as build-ups on wire feeder units (drive rollers, guides etc...), liners, torches and contact tips. This results in trouble-free feeding, a high process stability, reduced consumption of spare-parts and superior welding properties.

Classification & Chemical Composition (w%), Typical, Wire / Weld Metal

EN ISO 14341-A :G42 3CM G3SiI
AWS A5.18 :ER70S-6

C	Si	Mn
0,08	0,85	1,50
0,06 (*)	0,55 (*)	1,10 (*)

Welding Parameters, Available Sizes & Packaging

Current Type & Polarity : DC (+)

Arc (mm)	Dia. (mm)	Current (A)	Voltage (V)	Spool / Drum Weight (kg)
Short Arc	0.8	60 - 140	18 - 22	15
Short Arc	1.0	80 - 175	18 - 24	15
Short Arc	1.2	120 - 200	18 - 27	15
Short Arc	1.2	150 - 280	25 - 40	15

Approvals & Certificates



ISO 14001 : 2004

ISO 9001 : 2008

Authorized Importer for GCC, Middle East & Africa



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