

BLUE-ARC 16

- Low Hydrogen "H8" status
- Versatile / All Positional (Especially Vertical Up) Capabilities
- Reliable, Low Temperature Impact Toughness

Description and applications

BLUE-ARC 16 is a smooth running, basic low hydrogen electrode, developed for all position (except vertical down) welding, using AC or DC power sources. The thin coating allows ease of manipulation in joints with restricted area due to the ability to operate on low currents.

- Low spatter
- · Easily removable slag
- Suitable for A.C. or D.C. welding current supply

It is the ideal hydrogen controlled electrode for welding carbon, carbon manganese and low alloy high strength steels used in a multitude of critical and non-critical applications. This electrode can be used for one side welding of pipe and general butt joints of carbon steel and high tensile steel.

Classif	cation	
AWS A5.1	E7016	
JIS Z3211	D4316	

Typical all weld metal composition (wt%)

С	Mn	Si	Р	S
0.08	1.1	0.4	0.010	0.015

Typical all weld metal mechanical properties

Yield Stress 460 N/mm2	Tensile Srength 550 N/mm2	Elongation 28%	CVN Impact Values 100J @ -20 °C
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Welding positions





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BLUE-ARC 3R



- Rutile Type Electrode
- All Positional (Including Vertical Down) Capabilities
- Smooth, Stable Performance On All Welding Machines

Description and applications

BLUE-ARC 3R is a high rutile type electrode designed for manual arc welding in all position. Smooth mitre fillet welding can be obtained with short arc or 'touch' welding technique in the flat and horizontal / vertical fillet positions.

The electrodes outstanding and distinguish features are:

- Smooth and soft arc
- Automatic slag release
- · Easy restriking even at low voltage machine
- Low spatter and fume levels
- Suitable for A.C. or D.C. welding current supply

Particularly suitable for downhand fillet and butt welding, Blue-ARC 3R is especially recommended for welding of general structural steel fabrication such as gates, fences, trailer and furniture, etc.

Classification				
AWS A5.1	E 6013			
AS / NZS 1553.1	E 4113 Grade O			
JIS Z 3211	D 4313			
BS 639	E 4332 R21			

Typical all weld metal composition (wt%)

С	Mn	Si	Р	S
0.07	0.45	0.41	0.018	0.010

Typical all weld metal mechanical properties

Yield StressTensile SrengthElongationIn430 N/mm2490 N/mm226%In	CVN npact Values 32J @ 0 °C
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Welding positions



Distributed By:

BLUEMIG S6

BLUECORE 71T

BLUE-TIG S6



Description and applications

BLUEMIG S6 is a copper coated, low carbon steel GMAW wire, formulated for optimal performance under welding grade CO_2 and higher content CO_2 mixed gases. Arc transfer characteristics are excellent with Argon based gas mixtures, particularly in spray and pulsed modes of transfer. The high quality copper, coating of BLUEMIG S6 ensures smooth and stable feeding, good electrical contact and low tip wear.

BLUEMIG S6 is suitable for a wide range of welding applications on mild and medium strength steels. It is ideal for positional, single pass welding of sheet steel and steel pipes and tubes where the high silicon content promotes smooth and even weld beads with excellent wedge wetting and contours.

	Classif	ication	
A	WS A5.18	ER70S-6	
	JIS Z3312	YGW 12	

Typical all weld metal composition (wt%)

С	Mn	Si	Р	S
0.10	1.45	0.88	0.012	0.014

Typical all weld metal mechanical properties

Yield Stress	Tensile Strength
460 N/mm ²	560 N/mm ²
Elongation	CVN Impact Values
28%	80J @ -20°C

Welding positions





Description and applications

BLUECORE 71T is all position rutile cored wire for low risk medium carbon steel. It can be used for 100% CO_2 or 80% Argon 20% CO_2 gas mixture for shielding gas. The slag is easy to remove. The wire gives high deposition rate, consistency free from inclusion, porosity and x-ray soundness.

This wire is designed for single and multi-pass and performs well over mild scale and normal rust. Application will be on heavy wall thickness structural steel works, pressure vessel, shipbuilding, automotive and construction industries.

Classification

AWS A5.20 E 71T-1C

Typical all weld metal composition (wt%)				
C	Mn	Si	P	S
0.05	1.2	0.46	0.012	0.013

Typical all weld metal mechanical properties		
Yield Stress 480 N/mm ²	Tensile Strength 570 N/mm ²	
Elongation	CVN Impact Values	

105J @ -20°C

Welding positions

28%





Description and applications

BLUE-TIG S6 is a copper coated Mn-Si alloyed solid rod for GTAW of non-alloyed steels. Commonly used for butt or fillet welding of high pressure piping for shipbuilding, petrochemical and nuclear power plants etc.

BLUE-TIG S6 is an all-position welding rod for TIG welding. It is especially suitable for the root pass of pipe welding.

Classification		
AWS A5.18	ER70S-6	
EN 1668	W4Si1	

Typical all weld metal composition (wt%)			
С	Mn	Si	
0.08	1.7	0.80	

Typical all weld metal mechanical properties

Yield Stress	Tensile Strength	
520 N/mm ²	590 N/mm ²	
Elongation	CVN Impact Values	
31%	70J @ -29°C	

Welding positions



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