



WE BUILD™
with you



QUICK GUIDE STICK ELECTRODES



Elga® has been renowned for being the most demanding welders' choice ever since the very beginning. Starting as a family company in Gothenburg, Sweden, we have grown into a major supplier of consumables for the toughest and most challenging welding.

Today, we support welders across the globe with reliable consumables and know-how. As part of the global ITW group, we have the expertise and resources to continually improve welding quality as well as productivity.

Welcome to our world!



STICK ELECTRODE WELDING

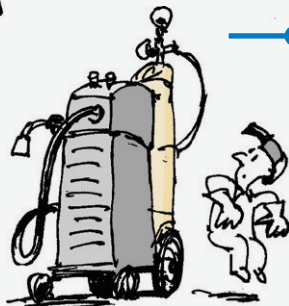
Welding with "stick" electrodes is a traditional and reliable welding method. It has many advantages and is superior to MIG/MAG/TIG welding, when used under the right circumstances.

USE COATED ELECTRODES



When you don't want to handle shielding gas at the site.

- The cost of shielding gas can be as large as the cost of the welding consumable.



When you don't want to use advanced and heavy welding machines.

- Large and complicated welding machines are often expensive. They also require maintenance of wear parts and conduits.



When you want great flexibility and short set-up times.

- The light and simple equipment is portable and easy to move between different work places and work levels.



When you work in restricted spaces.

- With coated electrodes and a small inverter it's easier to weld when it's cramped.



When it's hard to protect the site.

- MIG/MAG/TIG-welding requires the working site to be protected from the wind, which can be both time consuming and costly.



ALL YOU NEED

- Coated electrodes from Elga® and a small inverter.

STICK ELECTRODE WELDING

BASIC ELECTRODES For steel types S235 (St-37), S275 (St-44), S355 (St-52), NVA, NVA 32/36, NVD, NVD 32/36.
Provides a strong and tough weld and therefore has a wide range of usage.

■ You need to weld: **non-alloyed structural steel**

P 47D: easy to use

Double coated basic electrode, very easy to strike, also when used on small welding transformers. Suitable for thin-walled pipes, <8 mm. Installation, repair and maintenance work. Superb in root. DC+, AC OCV > 55 V.



P 51 / P 48S / P 48M: excellent impact properties

Basic universal electrodes for plates and tubes. Fast filling and good slag detachability in joints.

P 51: DC+/-, AC OCV > 70 V. For root passes: DC-.

P 48S: DC+/-

P 48M: DC+/-



P 52T: the red electrode for tack welding

Basic coated tack welding electrode. Very easy to strike/re-strike. Also for general maintenance welding. DC+, AC OCV > 50 V



DRYPAC® – MEANS A LOT TO YOUR CUSTOMERS:

- it means dry electrodes
- it means all new resealing possibilities
- it makes electrodes easier to store and handle
- it makes recycling easier and reduces waste of resources



P 62MR: low temperature applications

For -60°C-steel. Optimised welder-appeal, especially in the vertical up position, producing a finely rippled bead surface and good slag detachability. DC+/-, AC OCV > 70 V. For root passes: DC-.



RUTILE ELECTRODES For steel types S235 (St-37), S275 (St-44), NVA.
These electrodes are very easy to strike/re-strike.

P 43: smooth arc, nice bead profile

Rutile all positional multi-purpose electrode, smooth arc, self-detaching slag, nice bead profile. Suitable for a wide application range in mild steel. DC+/-, AC OCV > 50 V. For root passes: DC-.



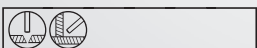
P 45S: fully positional multi-purpose

Rutile fully positional multi-purpose electrode which everybody can weld with. Suitable for a wide application range in mild steel. It is relatively insensitive to rust, dirt and surface coatings. DC+/-, AC OCV > 50 V. For root passes: DC-.



MAXETA™11: high speed fillet weld

Very fast welding electrode, high recovery. Use 700 mm electrode for increased productivity. Particularly suitable for high speed fillet welding in the downhand and horizontal-vertical positions as well as downhand butt welds. Minimum 250 A power source. DC+/- AC OCV > 50 V.



STICK ELECTRODE WELDING

STAINLESS STEEL 304L, 316L.

■ You need to weld: **stainless steel**

CROMAROD® 316L: smooth bead profile

Multi-purpose stainless steel electrode.

Operability is excellent with smooth low spatter and self-releasing slag. DC+. AC OCV > 39 V.



CROMAROD® 316LP: fully positional

Fully positional rutile flux coated electrode designed especially for welding thin walled pipes (down to 1.5 mm). Very easy to strike/re-strike - good for tack welding. Recommended for root runs on plates and pipes. DC+, AC OCV > 39 V.



CROMAROD® FAMILY: PERFECT WELD

- Self-detaching slag
- Clean, bright bead
- Smooth bead profile
- Absolute minimum spatter

HIGH DEGREE OF TRACEABILITY:

- The lot number is printed on each electrode



METAL CAN THE HIGHEST POSSIBLE PROTECTION:

- Hermetically sealed cans keep electrodes protected and ready to use when opened
- Easy open pull-tab with plastic lid to protect product after opening
- Very resistant to shocks
- No moisture pick up in any environment
- Small packing:
2.5-3 kg per can / 7.5-10 kg a box



■ You need to weld: **non-alloyed structural steel and stainless steel**

CROMAROD® 309L or 309MoL: dissimilar joint

Dissimilar joints between stainless and mild, low alloy or medium carbon steels. Very good weld bead appearance and self-releasing slag. DC+, AC OCV > 39 V.



■ You need to weld: **repair & maintenance**

ELGALOY HARD 60: moderate shock and abrasion

High recovery electrode for overlay welding. Produce a hardness of about 57-60 HRC.

Excellent for excavator teeth, bulldozer blades, swing hammers, crusher jaws, scrapers etc. Must be sanded, no machining. DC+, AC.



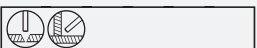
CROMAROD® 312: the blue electrode, the problem solver

Excellent tolerance to dilution from dissimilar and difficult-to-weld materials, high carbon hardenable tool, die and spring steels without hot cracking. 230 HV to 450 HV, can be machined. DC+, AC OCV > 39 V.



ELGALOY MIX 18: buffer layer

High recovery electrode for productive welding. For joining and buffering on manganese steel. Plain welding on rails, rail crossings, crane wheels, etc. The deposit work hardens from 200 HV to 450 HV. Can be machined. DC+, AC.



ELGALOY CAST-NiFe: cast iron

Cast iron electrode. Also suitable for joining cast iron against mild, low alloy and stainless steel. Machine bases, transmission housings, gear boxes, engine blocks and pump bodies etc. DC+/-, AC.



Notes

Please contact your local ITW Welding sales office for more information:

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WE BUILD™ *with you*

We develop and manufacture reliable consumables for your welding applications that deliver exceptional performance, even in some of the world's most rugged and extreme environments. We build with you, providing our welding consumables that meet the high demands of your work and workplace.

Elga® products support all welding processes with all types of base materials, from standard carbon manganese steels to exclusive nickel alloys. In addition to standard welding consumables, we also create custom solutions with our customers to meet their specific needs.

Join our world!



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