



Certanium 707SP Gold

Ultra high quality Crack Resistant Dissimilar Steel Electrode



Part N°: 84270 2.4mm
 84271 3.2mm
 84272 4.0mm

Features

- All position AC/DC coated electrode
- Crack free deposits
- Superior performance on limited input AC machines....

Applications

- All carbon and alloy steels; low, medium, high in all positions. All tool steels, manganese steels and specialty steels in thick-to-thin designs. Will actually deposit on noncommercial AC or DC power sources having very low open circuit voltage characteristics. Welds fillets with no slag interference.

Benefits

- Weld without dis-assembly
- Quality repair
- Quality repair on most equipment

Instructions

- Clean surface. Adjust amperage within recommended range and deposit material maintaining short to medium arc length. Tilt electrode 15° in the direction of travel. For rapid filleting raise amperage slightly and drag weld inclining the electrode 45° in the direction of travel. Back-whip craters and remove slag between passes.

Part no	diameter	AC or DC reverse polarity
84270	2.4mm	35-70
84271	3.2mm	60-110
84272	4.0mm	75-140

Technical Information

Part number:	84270 2.4mm	Weight:	1KG
	84271 3.2mm	Customs Tariff Code:	8311 10 10
	84272 4.0mm	SDS:	yes
Description:	Electrode	Unit of measure:	kg
Shelf life:	18 mths	Tensile Strength:	128,000 psi (880 MPa)
Selling Unit:	kg	Impact Energy:	50J (20°C)
Packaging:	plastic box (5kg per box)	Elongation:	32%
Label codes:	08 + 10	Hardness:	Rockwell B 97

Diameter (mm)	Weldmetal/ Electrode (g)	Electrodes per Kg of Weldmetal	Arc Time of Deposition (min/Kg)	Current Setting (A)
4.0	28	36	46	130
3.2	18	55	58	100
2.4	11	88	82	65



SDS available on www.kenturope.com

Terms and Conditions

No part of this publication may be reproduced, transmitted or stored, electronically, mechanically or photocopied without the prior permission of KENT (United Kingdom) Ltd. This data sheet and its contents (the "Information") belong to the KENT (United Kingdom) Ltd or are licensed to it. No license is granted for the use of it other than for information purposes in connection with the products to which it relates. No license of any intellectual property rights is granted.

The Information is subject to change without notice and replaces all data sheets previously supplied. The Information supplied is believed to be accurate but the Group assumes no responsibility for its accuracy or completeness, any error from or omission in it nor for any use made of it. Users of this data sheet should check for themselves the Information and the suitability of the products for their purpose and not make any assumptions based on information included or omitted. Liability for loss or damage resulting from any reliance on the Information or use of it (including

liability resulting from negligence or where the Group was aware of the possibility of such loss or damage arising) is excluded. This will not operate to limit or restrict the Group's liability for death or personal injury resulting from its negligence KENT is the trading name of KENT (United Kingdom) Ltd

Registered Office: Amber House, Showground Road, Bridgewater, Somerset, United Kingdom, TA6 6AJ
All rights reserved.

KENT (United Kingdom) Ltd, Forsyth House, Pitreavie Drive, Pitreavie Business Park, Dunfermline, Fife, KY11 8US
Tel : 0800 136925 or 01383 723344 between 08:30-17:30 Monday-Thursday, 09:00-15:00 on Fridays.
 For out of hours queries please **Fax** us on 01383 735829 or **Email:** kentinfo.uk@kenturope.com

Rev: 24/05/2017