

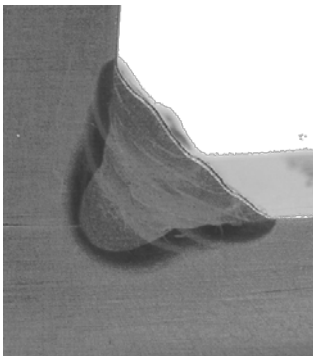
Hydroweld FS

WET WELDING ELECTRODES

Hydroweld FS wet welding electrodes are the result of significant research and development into flux formulations, filler metals and supplementary coatings. They are designed to work in all positions in fresh water or brine to a depth of at least 100 metres, their outstanding user friendly properties and wet welding characteristics, easily produce high quality wet welds to internationally recognised standards.

Hydroweld FS have rapidly become the industry standard where high quality wet welding is required. They can meet the requirements of **AWS D3.6M-99 class 'A' fillet wet welds** as has been witnessed by Lloyds Register of Shipping (LRS), American Bureau of Shipping (ABS), Det Norske Veritas (DNV), Bureau Veritas (BV), Rina and Germanischer Lloyd (GL).

Hydroweld FS wet welding electrodes are currently the only wet welding electrodes approved for permanent and temporary repairs to war ships by the British Ministry of Defence (MoD). This was gained after intensive underwater comparability testing and further non destructive and destructive testing against all other commercially available wet welding electrodes by the MoD and The Welding Institute (TWI) and as a result the electrodes are now included in the NATO codification system.



Hydroweld FS electrodes are available in 3.2 mm x 350 mm in boxes of 90 electrodes or 4 mm x 350 mm in boxes of 60 electrodes and/or cartons of 5 boxes. We carry over 100,000 electrodes, which can be dispatched on the day of the order via a method to suit the clients' requirements i.e. next day, 2-3 day delivery etc.

Hydroweld FS users have access to unrivalled product support. This support includes the qualification of wet welding procedures and welder qualifications to internationally recognised specifications such as the AWS D3.6M-99. Advice on electrode application, provision of suitably trained and qualified welder divers, wet welder training, hire and sale of wet welding and associated equipment, joint or co-operative projects, project management and technical support.



TYPICAL PROPERTIES

UNDILUTED WELD METAL MECHANICAL PROPERTIES		UNDILUTED WELD METAL COMPOSITION BY % WT		<ul style="list-style-type: none"> ✓ General purpose wet welding electrodes ✓ Enhanced rutile flux coated ✓ Optimum size for easy manipulation ✓ Each marked HYDROWELD FS ✓ Simple to use in all positions ✓ Easy to strike and re-strike ✓ Smooth and easily maintained, clearly visible arc ✓ High metal transfer efficiency ✓ Excellent root penetration and sidewall fusion ✓ Finely rippled, well shaped beads ✓ Self releasing slag ✓ Rapidly produce high quality wet welds to international standards
UTS.	510 N/mm ²	C.	0.1	
YS.	460 N/mm ²	Mn.	0.5	
Elongation Av.	17 %	Si.	0.43	
Reduction in area	32 %	P.	0.015	
Av. Hardness	175 Hv ₁₀	Mo.	0.01	
CVN	@ 0°C 55 J	S.	0.008	
	@ -20°C 45 J			
	@ -30°C 32 J			

For further information or free sample please contact:

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Where standards are set for welding in the wet