



ELECTRODES



ELECTRODES

DYNAWELD OFFERS AN EXTENSIVE RANGE OF MULTI-PURPOSE WELDING ELECTRODES TO SUIT A VARIETY OF APPLICATIONS INCLUDING GENERAL WELDING, REPAIRS, MAINTENANCE AND INDUSTRIAL FABRICATION. THE RANGE OF ELECTRODES INCLUDES GENERAL PURPOSE, HYDROGEN CONTROLLED, STAINLESS STEEL, CAST IRON, ALUMINIUM, HARDFACING AND LOW ALLOY AS WELL AS GOUGING CARBONS FROM RESPECTED BRANDS SUCH AS BOSSWELD, GEMINI, INE AND KOBE.

ELECTRODES

GENERAL PURPOSE ELECTRODES

GEMINI 13 ELECTRODES

AWS A5.1 E 6013

Rutile type electrode, used for all general fabrication work where the best appearance is required. With mechanical properties this electrode is suitable for structural steel, plate, sheet steels, tubular sections or any general steel application.

FEATURES

- Smooth running electrode
- Easy to strike
- Beautiful weld bead appearance

APPLICATIONS

- General welding
- Galvanized steel
- Thin sheet or tubing
- Rural maintenance and fabrication

WELDING POSITIONS

- All positions excluding vertical down

SIZE	PKT	CTN	PART NO.
2.0mm	2Kg	20Kg/ctn	100029
2.0mm	6stk/pkt	-	100029H
2.6mm	2Kg	20Kg/ctn	100030
2.6mm	6stk/pkt	-	100030H
3.2mm	5Kg	20Kg/ctn	100031
3.2mm	6stk/pkt	-	100031H
4.0mm	5Kg	20Kg/ctn	100032



GEMINI 11

AWS A5.1 E 6011 CELLULOSE

On both AC and DC current, Gemini 11 electrodes are a fast freezing rod, meaning that the weld puddle changes from liquid to solid rapidly and holds up well in difficult welding positions.

FEATURES

- Thin flux coating
- Deep, forceful arc
- Versatile electrode
- Fast freezing weld metal

APPLICATIONS

- Single sided weld joints
- Pipe butt welds
- Galvanized steel
- Ideal for welding joints which are dirty or oily

WELDING POSITIONS

- All positions



SIZE	PKT	CTN	PART NO.
2.6mm	5Kg	20Kg/ctn	100110
3.2mm	5Kg	20Kg/ctn	100111
4.0mm	5Kg	20Kg/ctn	100112

GENERAL PURPOSE ELECTRODES

GEMINI 12

AWS A5.1 E 6012

Rutile type electrode, with easy starting characteristics, can be used for all general welding of structural steel, wrought iron, gates, galvanised steel and thinner sections. Recommended for the less experienced welder as they are easy to use.

FEATURES

- Versatile electrode
- Easy to strike
- One amperage for a range of positions

APPLICATIONS

- General welding
- Galvanized steel
- Thin sheet or tubing
- Duragal structures
- Rural maintenance and fabrication

WELDING POSITIONS

- All positions



SIZE	PKT	CTN	PART NO.
1.6mm	2Kg	20Kg/ctn	1000116
2.0mm	2Kg	20Kg/ctn	100011
2.6mm	2Kg	20Kg/ctn	100012
3.2mm	5Kg	20Kg/ctn	100013
4.0mm	5Kg	20Kg/ctn	100014

INE 46 BLUE

AWS A5.1 E 6013

Rutile coated electrode (blue coating), featuring a quick arc start that allows for a smooth running electrode and self releasing slag.

FEATURES

- Smooth running electrode
- Easy to strike
- Self releasing slag
- Beautiful weld bead appearance

APPLICATIONS

- General welding
- Galvanized steel
- Thin sheet or tubing
- Rural maintenance and fabrication
- Duragal structures

WELDING POSITIONS

- All positions excluding vertical down



SIZE	PKT	CTN	PART NO.
2.5mm	5Kg	15Kg/ctn	100333
3.25mm	5Kg	15Kg/ctn	100334
4.0mm	5Kg	15Kg/ctn	100335

KOBELCO RB26

AWS A5.1 E 6013

High titania type covered electrode. A popular choice as arc is stable with little spatter. Downhand welding in the vertical position becomes easy with this rod and results in a beautiful bead appearance.

FEATURES

- Smooth running electrode
- Easy to strike
- One amperage for a range of positions

APPLICATIONS

- General welding
- Galvanized steel
- Thin sheet or tubing
- Rural maintenance and fabrication
- Ship repairs

WELDING POSITIONS

- All positions excluding vertical down



SIZE	PKT	CTN	PART NO.
2.6mm	5Kg	20Kg/ctn	100039
3.2mm	5Kg	20Kg/ctn	100040
4.0mm	5Kg	20Kg/ctn	100041
5.0mm	5Kg	20Kg/ctn	100042

ELECTRODES

HYDROGEN CONTROLLED ELECTRODES

KOBE LB52-18

AWS A5.1 E 7018

An iron powder low hydrogen covered electrode for all-positional welding. Excellent X-ray soundness and mechanical properties. Smooth arc, neat bead appearance and easy slag removal. For use with heavy structures, rolling stock and heavy machinery.

FEATURES

- Excellent arc stability
- Suitable for high tensile steels
- Tough weld metal
- Higher deposition rates than an E7016

APPLICATIONS

- Structural steel
- Earth moving equipment
- Pipe welding
- Pressure vessels

WELDING POSITIONS

- All positions



SIZE	PKT	CTN	PART NO.
2.6mm	5Kg	20Kg/ctn	100061
3.2mm	5Kg	20Kg/ctn	100062
4.0mm	5Kg	20Kg/ctn	100063

KOBE LB52-U

AWS A5.1 E 7016

Designed specifically for root runs on one side welding of pipes and general structures. Good arc stability, slag removability and smooth weld beads. This quality electrode has proven to be a popular choice and is used in many critical applications.

FEATURES

- Excellent arc stability
- Designed for single sided butt joint root run
- Suitable for high tensile steels
- Tough weld metal

APPLICATIONS

- General welding
- Rural maintenance and fabrication
- Root run on pipe butt joints or plates
- Tilt slab construction
- Maintenance workshops

WELDING POSITIONS

- All positions excluding vertical down



SIZE	PKT	CTN	PART NO.
2.6mm	5Kg	20Kg/ctn	100053
3.2mm	5Kg	20Kg/ctn	100054
4.0mm	5Kg	20Kg/ctn	100055

GEMINI LD52U

AWS A5.1 E 7016

Low hydrogen, double coated electrode recommended for unalloyed, micro-alloyed and low alloyed steels of the medium tensile class. Suitable for root passes and all-positional welding, excluding vertical down. Has an extremely stable arc and is not effected by rust/paint on work surface.

FEATURES

- Twin flux coated
- Tough weld metal
- Low hydrogen levels
- Easy to use on AC and DC power sources

APPLICATIONS

- General welding
- Rural maintenance and fabrication
- Root run on pipe butt joints or plates
- Tilt slab construction
- Maintenance workshops

WELDING POSITIONS

- All positions excluding vertical down



SIZE	PKT	CTN	PART NO.
2.6mm	5Kg	20Kg/ctn	100035
2.6mm	6stk/pkt	-	100035H
3.2mm	5Kg	20Kg/ctn	100036
3.2mm	6stk/pkt	-	100036H
4.0mm	5Kg	20Kg/ctn	100037

HYDROGEN CONTROLLED ELECTRODES

INE RB 86 ELECTRODES

AWS A5.1 E 7016

Special double coated (rutile-basic) electrode used for the welding of carbon and carbon-manganese steels with tensile strength of up to 510 Mpa. Particularly designed for both AC and DC welding, it is suitable for maintenance work, structural steel and earth moving applications. Hermetically sealed packaging for factory freshness.

FEATURES

- Twin flux coated low hydrogen electrode
- Very low hydrogen levels
- Used for the welding of carbon and carbon-manganese steels

APPLICATIONS

- Structural steel
- Earth moving equipment
- Tilt slab construction

WELDING POSITIONS

- All positions excluding vertical down

SIZE	PKT	CTN	PART NO.
2.5mm	1.9Kg	9 Kg/ctn	100340
3.25mm	1.6Kg	9.6 Kg/ctn	100341
4.0mm	2Kg	12 Kg/ctn	100342



GEMINI 7024

AWS A5.1 E 7024

Easy striking, rutile type, full iron powder electrode for structural steel welding in the downhand and horizontal positions. Suitable in production or general fabrication where highest deposition rates are required.

FEATURES

- High iron powder electrode
- Smooth running
- Low spatter levels
- Excellent deposition rates (up to 130%)

APPLICATIONS

- Structural steel
- Tank fabrication
- Ship structures
- On site beam fabrication

WELDING POSITIONS

- Flat and downhand only



SIZE	PKT	CTN	PART NO.
3.2mm	5Kg	20Kg/ctn	100045
4.0mm	5Kg	20Kg/ctn	100046
5.0mm	5Kg	20Kg/ctn	100047

ELECTRODES

STAINLESS STEEL ELECTRODES

GEMINI 316L-16
ELECTRODES

AWS A5.4 E 316L-16

Stainless steel electrode for welding common 300 series stainless steel, including 301, 302, 304, 304L, 316 and 316L leaving a smooth weld deposit of excellent appearance.

FEATURES

- Rutile type flux coating
- Easy to operate
- Handy 1Kg pack
- Excellent weld bead appearance

APPLICATIONS

- General welding of 301, 302, 304, 304L, 316, 316L stainless steels

WELDING POSITIONS

- Flat, horizontal, vertical up and overhead

SIZE	PKT	CTN	PART NO.
2.0mm	1Kg	20Kg/ctn	100022
2.0mm	6stk/pkt	-	100022H
2.6mm	1Kg	20Kg/ctn	100023
2.6mm	5Kg	20Kg/ctn	1000235
2.6mm	6stk/pkt	-	100023H
3.2mm	1Kg	20Kg/ctn	100024
3.2mm	5Kg	20Kg/ctn	1000245
3.2mm	6stk/pkt	-	100024H
4.0mm	1Kg	20Kg/ctn	100025



GEMINI 309Mo-16

AWS A5.4 E 309Mo-16

Rutile type electrode, recommended for welding 309 and 309L stainless steels. Also suitable for welding dissimilar metals; mild steel to stainless steel. Low spatter and smooth running.

FEATURES

- Rutile type flux coating
- Easy to operate
- Handy 1Kg pack
- Excellent weld bead appearance

APPLICATIONS

- Dissimilar metals
- Buffer layer for stainless cladding
- Suitable for 309 and 309L stainless steels

WELDING POSITIONS

- Flat, horizontal, vertical up and overhead



SIZE	PKT	CTN	PART NO.
2.6mm	1Kg	20Kg/ctn	100009
3.2mm	1Kg	20Kg/ctn	100010

STAINLESS STEEL ELECTRODES

GEMINI 347

AWS A5.9 E 347

A rutile coated electrode for welding corrosion resistant, stabilised CrNi steels. Also suitable for applications of heat resistant steel up to 800°C. Offers a smooth weld, with directed arc and a clean edge.

FEATURES

- Rutile type flux coating
- Easy to operate
- Handy 1Kg pack
- Excellent weld bead appearance

APPLICATIONS

- Suitable for high temperature applications
- Excellent for welding 321,347 and 348 stainless steels

WELDING POSITIONS

- Flat, horizontal, vertical up and overhead



GEMINI

SIZE	PKT	CTN	PART NO.
2.6mm	1Kg	20Kg/ctn	100026
3.2mm	1Kg	20Kg/ctn	100027

GEMINI 308L-16

AWS A5.4 E 308L-16

Rutile type electrode containing low amounts of carbon, depositing weld metal suitable for welding 301, 302, 304, 308 and 308L stainless steels, leaving a very smooth weld with a clean edge.

FEATURES

- Rutile type flux coating
- Easy to operate
- Handy 1Kg pack
- Excellent weld bead appearance

APPLICATIONS

- Suitable for 301, 302, 304, 308 and 308L stainless steels

WELDING POSITIONS

- Flat, horizontal, vertical up and overhead



GEMINI

SIZE	PKT	CTN	PART NO.
2.6mm	1Kg	20Kg/ctn	100006
3.2mm	1Kg	20Kg/ctn	100007

GOUGING CARBONS

BOSSWELD DC GOUGING CARBONS

Copper coated carbon electrode designed for gouging and cutting with DC current. Provides high efficiency at low consumption. For use in removal of residual casting material and weld defects. Also cuts bronze, stainless steel and copper.

FEATURES

- Suitable for air arc gouging
- Excellent cutting efficiency
- Excellent for the fast removal of weld defects

APPLICATIONS

- Maintenance workshops
- Oil and gas refineries
- Removal of weld defects
- Boilers and pressure vessel fabrication

WELDING POSITIONS

- All positions excluding vertical down



BOSSWELD

SIZE	PKT	PART NO.
4.8mm	50pc/pkt	100195
6.4mm	50pc/pkt	100196
8.0mm	50pc/pkt	100197
9.5mm	50pc/pkt	100198
12.7mm	50pc/pkt	100200

ELECTRODES

SPECIAL ELECTRODES

HARRIS ALUMINIUM DC

AWS A5.1 E 4043

Coated electrode providing high speed deposition of dense, machinable welds. Use for fabrication and repair of cast and wrought aluminium, foundry defects, machining errors and salvage work. Ideal for repairs and maintenance. (DC reverse polarity only).

FEATURES

- Low cost setup for small jobs
- Versatile
- DC- only
- Extruded electrode for MMAW Aluminium

APPLICATIONS

- Repair and maintenance of cast and wrought aluminium
- Maintenance and repair workshops
- Foundry defects

WELDING POSITIONS

- Flat, horizontal, vertical up and overhead



SIZE	PKT	CTN	PART NO.
3.2mm	0.454Kg	2.27Kg/ctn	100103

GEMINI 680 DISSIMILAR WELDALL

AWS A5.4 E 312-16

Rutile austenitic-ferritic coated electrode with 25-35% ferrite content. Weld metal is crack resistant and enables the welding of dissimilar steels. A great choice for repair and maintenance welding of unknown steels.

FEATURES

- Crack resistant welds
- Easy to use
- Smooth weld bead
- Versatile Weldall electrode

APPLICATIONS

- Excellent maintenance electrode
- Railway iron
- Buffer layer prior to hard facing
- General repair and maintenance

WELDING POSITIONS

- Flat, Horizontal, Vertical Up and Overhead



SIZE	PKT	CTN	PART NO.
2.6mm	1Kg	20Kg/ctn	100018
2.6mm	6stk/pkt	-	100018H
3.2mm	1Kg	20Kg/ctn	100019

GEMINI NICKEL ARC 98

AWS A5.15 E Ni-CI

Pure Nickel electrode which is universally used for welding all types of cast iron. Designed to operate at low currents which minimise heat input and facilitates the cold welding of cast iron. Weld induced stresses can be reduced by hammer peening.

FEATURES

- Used on all types of cast iron
- Low amperage
- Ductile weld beads
- Refined grain structure

APPLICATIONS

- Suitable for most cast irons
- Pumps and block repairs
- All maintenance workshops
- Cast iron grate repair

WELDING POSITIONS

- Flat, horizontal, vertical up and overhead



SIZE	PKT	CTN	PART NO.
2.6mm	1Kg	20Kg/ctn	100092
3.2mm	1Kg	20Kg/ctn	100093
3.2mm	6stk/pkt	-	100093H
4.0mm	1Kg	20Kg/ctn	100094

LOW ALLOY ELECTRODES

INE 55 B

AWS A5.5 E 7018-1

Basic coated electrode designed for welding carbon and carbon-manganese steels with tensile strength up to 510 Mpa. Intended for highly stressed weld joints which require a weld deposit with very low H2 levels. Excellent for X-ray quality welds.

FEATURES

- Higher manganese levels for high 'impact toughness'
- Forceful, controllable arc with high metal recovery rate

APPLICATIONS

- Oil and gas industry
- Pressure vessels
- Ship building
- Highly restrained joints

WELDING POSITIONS

- All positions excluding vertical down



SIZE	PKT	CTN	PART NO.
2.5mm	5Kg	15Kg/ctn	100320
3.25mm	5Kg	15Kg/ctn	100321
4.0mm	5Kg	15Kg/ctn	100322

INE 57 B MO

AWS A5.5 E 7018-A1

Low alloy basic coated electrode with 0.5% molybdenum addition designed for welding low-alloy steels and creep-resistant steels with high tensile strength. Hermetically sealed packaging for factory freshness.

FEATURES

- Low alloy 0.5% molybdenum electrode for welding Low Alloy and Creep resistant steel
- Forceful, controllable arc with high metal recovery rate
- Excellent for X-ray quality welds

APPLICATIONS

- Chemical industry
- Pressure vessels and heat exchangers
- Molybdenum bearing pipelines and plates

WELDING POSITIONS

- All positions excluding vertical down



SIZE	PKT	CTN	PART NO.
2.5mm	2Kg	12Kg/ctn	100310
3.25mm	2Kg	12Kg/ctn	100311
4.0mm	2Kg	12Kg/ctn	100312

INE B2

AWS A5.5 E 8018-B2

Low alloy basic coated electrode with 1.25% Cr and 0.5% Mo content to be used for the welding of creep resistant steels. Also suitable for the welding of steels with 0.9% Cr and 0.5% Mo content. Hermetically sealed packaging for factory freshness.

FEATURES

- Low alloy chrome moly 1 basic coated electrode for welding creep resistant steel
- 1 1/4% chrome, 1/2% molybdenum
- Excellent for X-ray quality welds

APPLICATIONS

- Chemical industry
- Power stations
- Creep resistant steels
- Heat exchangers, boilers and boiler tubes

WELDING POSITIONS

- All positions excluding vertical down



SIZE	PKT	CTN	PART NO.
2.5mm	2Kg	12Kg/ctn	100301
3.25mm	2Kg	12Kg/ctn	100302
4.0mm	2Kg	12Kg/ctn	100303

ELECTRODES

LOW ALLOY ELECTRODES

INE B3

AWS A5.5 E 9018-B3

Low alloy basic coated electrode with 2.25% Cr and 1% Mo content to be used for the welding of creep resistant steel. Hermetically sealed packaging for factory freshness.

FEATURES

- Low alloy chrome-moly 2 basic coated electrode for welding creep resistant steel
- 2 1/4% chrome, 1% molybdenum
- Excellent for X-ray quality welds

APPLICATIONS

- Chemical industry
- Power stations
- Creep resistant steels
- Heat exchangers, boilers and boiler tubes

WELDING POSITIONS

- All positions excluding vertical down



SIZE	PKT	CTN	PART NO.
2.5mm	2Kg	12Kg/ctn	100304
3.25mm	2Kg	12Kg/ctn	100305
4.0mm	2Kg	12Kg/ctn	100306

HARDFACING ELECTRODES

GEMINI H 350R

DIN 8555 E 1-UM-350

General purpose rutile coated hardfacing electrode depositing tough chromium manganese alloy weld metal. Recommended where maximum hardness and reasonable machinability is required. Suitable as buffer layer on badly worn components. 32-35 HRC. Build up of sacrificial components in metal to metal wear applications.

FEATURES

- Tough chromium manganese alloy weld metal
- Hardfacing electrode 32HRC Single layer, 35HRC multiple layers

APPLICATIONS

- Metal to metal wear applications
- Buffer layer on badly worn parts
- Gears, Idler wheels, tracks
- Cable sheaves

WELDING POSITIONS

- Flat, horizontal and vertical up



SIZE	PKT	CTN	PART NO.
3.2mm	5Kg	20Kg/ctn	100184
4.0mm	5Kg	20Kg/ctn	100185

GEMINI H 600R

DIN 8555 E 6-UM-55

A rutile coated electrode for welding corrosion resistant, stabilised CrNi steels. Also suitable for applications of heat resistant steel up to 800°C. Offers a smooth weld, with directed arc and a clean edge.

FEATURES

- Extends the operation life of many wearing parts
- Excellent abrasion resistance to medium impact
- Hardfacing electrode 52HRC Single layer, 55HRC multiple layers

APPLICATIONS

- Metal to metal wear applications
- Buffer layer on badly worn parts
- Gears, Idler wheels, tracks
- Cable sheaves

WELDING POSITIONS

- Flat, horizontal and vertical up



SIZE	PKT	CTN	PART NO.
3.2mm	5Kg	20Kg/ctn	100186
3.2mm	6stk/pkt	-	100186H
4.0mm	5Kg	20Kg/ctn	100187

HANDY PACKS

BOSSWELD ELECTRODE HANDY PACKS

Handy packs are the ideal solution for small welding jobs and repairs.

Conveniently stored in a resealable polycarbonate tube, each pack contains 6 electrodes and is available in 3 diameter sizes including 2.0mm, 2.6mm and 3.2mm. Handy packs are suitable for the welding of mild steel, cast iron, stainless steel, Weldall and for small hardfacing build up applications.

FEATURES

- Colour coded for easy recognition
- Broad range
- Retail ready
- Airtight for longer shelf life

TYPE	SIZE	PKT	PART NO
Gemini 13	2.0mm	6 sticks	100029H
Gemini 13	2.6mm	6 sticks	100030H
Gemini 13	3.2mm	6 sticks	100031H
Gemini LD52U	2.6mm	6 sticks	100035H
Gemini LD52U	3.2mm	6 sticks	100036H
Gemini 316L-16	2.0mm	6 sticks	100022H
Gemini 316L-16	2.6mm	6 sticks	100023H
Gemini 316L-16	3.2mm	6 sticks	100024H
Gemini 680 Dissimilar	2.6mm	6 sticks	100018H
Gemini Nickel Arc	3.2mm	6 sticks	100093H
Gemini H 600R	3.2mm	6 sticks	1000186H



BOSSWELD
RELIABLE WELDING GEAR

