

Classification

AWS A5.1	AWS A5.1M	EN ISO 2560-A	EN ISO 2560-B	IS 814
E 7018	E 4918	E 42 3 B 3 2 H5	E 49 18 AP H5	EB 54 26 H3 JX

Characteristics and field of use

- Basic coated electrode with very good welding characteristics, including out of position work.
- High impact properties at -30°C, thus produces tougher weld.
- Weld metal recovery about 115%, thus higher productivity.
- Extremely good slag detachability thus greater weld appeal.
- Low spatter and finely rippled bead with regular profile reduces post weld dressing operations.
- Weld of consistent radiographic quality is achieved.

Base Materials

S235JRG2 – S355J2, E295, E335, C35; boiler steels P235GH, P265 GH, P295GH, P355GH; fine grained structural steels up to S420N; shipbuilding steels A, B, D, E; offshore steels; pipe steels P265, P295, L290NB – L415NB, L290MB – L415MB, X42 – X56; cast steels GS-38, GS-45, GS-52; ageing resistant steels Ast35 – Ast52

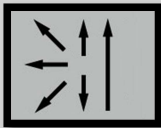
Typical Composition of all weld metal (wt. - %)

C	Si	Mn	S	P	Cr	Mo	Ni
0.050	0.40	1.20	0.020	0.025	0.020	0.003	0.015

Mechanical Properties of all weld

Heat treatment (PWHT)	Yield strength R _e N/mm ²	Tensile strength R _m N/mm ²	Elongation (L ₀ =4d ₀)	Impact Test Values @ -30°C
	MPa	MPa	%	J
As Welded	460	550	28	100
PWHT (610°C/12Hrs.)	432	530	30	110

Operating data

Position	Polarity	Re-drying/baking conditions:	Ø(mm)	L	Amps
	DCEP /AC (>70V)	Re-drying at 250-350°C for 2-3 Hrs recommended.	2.50	350	80 -110
			3.15	350/450	100-140
			4.00	450	130-180
			5.00	450	180-220

Size & Packaging	Size	Kg./Pack	Kg./Box
	2.50x350	5.0	20.0
	3.15x350/450	5.0	20.0
	4.00x450	5.0	20.0
	5.00x450	5.0	20.0

Approvals

IBR, IRS, LRS, BV, ABS