

**Brand Name & Classification**

AWS/ASME SFA-5.4: E7048 G  
DIN 1913: E 51 43 B 9  
EN 499: E 42 2 B 15 H 10

**Properties**

Electrode particularly designed for vertical down welding in shipbuilding and steel constructions: preferably for fillet welds. Suitable for welding primer painted components.

**Application**

Unalloyed structural steel: St33 to St52-3  
Boiler plates: HI, HII, 17Mn4  
Fine grain structural steels: StE255 to StE 355, WstE255 to WstE 355  
Shipbuilding steels: A, B, D, E, AH 32 to EH 36  
Cast steel: GS-38 to GS-52

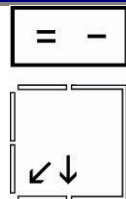
**Weld Metal Analysis  
Typical values**

Carbon: 0.08  
Silicon: 0.60  
Manganese: 1.10

**Typical Mechanical properties**

Yield Strength	Tensile Strength	Elongation	Impact Strength
>420 N/MM2	500 – 640 N/mm2	> 23 %	100 J at +20 c 55 J at -20 c

**Welding Current & Positions**



**Current**

Dia	Length	Amperes
2.6	350	70-100
3.2	400/450	90-140
4.0	400/450	140-190
5.0	400/450	190-250