

Brand Name & Classification

AWS/ASME SFA-5.1:E 7018
DIN 1913: E 51 55 B 10
EN 499: E 42 6 B 42 H 10

Approvals Grade

ABS
DNV
LRS 5Y40H5
BV
GL

Properties

Electrode for producing crack free welded joints with good toughness properties even on steels having a carbon content up to 0.4 %. Weld metal recovery is approximately 120 %. Good operating characteristics even in positional welding. Weld metal exhibits good toughness properties down to -600 c. Electrode is suitable for depositing buffer layers on steels having a higher carbon content

Application

Unalloyed structural steel: St33 to St52-3
Boiler plates: HI, HII, 17Mn4
Pipe steels: St52.4, St35.8, StE210.7 to StE360.7 1 including corresponding TM grades
Fine grain structural steels: StE255 to StE 355, WstE255 to WstE 355
Shipbuilding steels: A, B, D, E
Cast steel: GS-38 to GS-52

Weld Metal Analysis Typical values

Carbon: 0.08

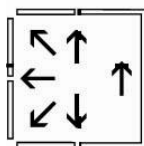
Silicon: 0.50

Manganese: 1.10

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
			200 J at +20 ⁰ c
>420 N/MM2	500 – 640 N/mm2	> 26 %	150 J at 0 ⁰ c
			80 J at -60 ⁰ 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