

## Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 42 5 B 3 2 H5	E 4918-1 AU H5	E7018-1	E4918-1

## Characteristics and typical fields of application

Basic covered electrode offers very good welding characteristics including out of position welding. Weld metal recovery ~ 110 %. Suitable for steel constructions, shipbuilding, boiler fabrication, tank constructions, bridge building and vehicle manufacturing.

## Base materials

S235JR-S355JR, S235JO-S355JO, S235J2-S355J2, S275N-S420N, S275M-S420M, S275NL-S420NL, S275ML-S420ML, P235GH-P355GH, P275NL1-P355NL1, P275NL2-P355NL2, P215NL, P265NL, P355N, P285NH-P420NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L245MB-L415MB, GE200-GE240, GE300

ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1, LF2; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr 58, 65, 70; A 588 Gr. A, B; A 633 Gr. A, C, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 711 Gr. 1013; A 841 Gr. A, B, C; API 5 L Gr. B, X42, X52

## Typical analysis of all-weld metal

	C	Si	Mn
wt-%	0.07	0.4	1.2

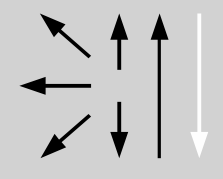
## Mechanical properties of all-weld metal – typical values (min values)

Heat-treatment	Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	-50 °C
u	<b>420</b> (≥ 420)	<b>510</b> (≥ 510)	<b>25</b> (≥ 20)	<b>190</b>	<b>70</b> (≥ 47)
s	400	500	26	130	47

u untreated, as welded

s stress released 580°C/15h

## Operating data

	<b>Polarity:</b> DC ( + ) AC	<b>Redrying:</b> 250 – 350 °C / 2 h	ø mm	L mm	Amps A
			2.5	350	65 – 110
			3.2	350/450	100 – 145
			4.0	450/450	135 – 200
			5.0	450	180 – 280
6.0	450	240 – 375			

## Approvals

TÜV (09449.), ABS, DNV GL, LR, CE