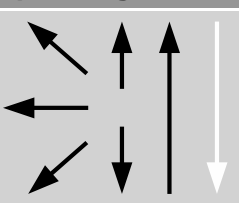


Classification									
AWS A5.1		AWS A5.1M		EN ISO 2560-A		EN ISO 2560-B			
E7018 H4R		E4918H4R		E 42 3 B 42 H5		E 49 18 A U H5			
Characteristics and typical fields of application									
<ul style="list-style-type: none"> • Basic covered electrode with very good welding characteristics including out of position work. • Weld metal recovery about 115%*. • Crack-free weld metal when welding high-carbon steels. • Suitable for use in tank construction, boiler and pressure vessel manufacturer, apparatus engineering, vehicle manufacture, offshore applications and ship building. 									
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; SA 516 Gr 60, 65, 70; SA333 Gr 6.									
Typical analysis of all weld metal (wt.-%)									
C		Si		Mn		P		S	
0.08		0.50		1.40		0.009		0.01	
Mechanical properties of all-weld metal									
Heat treatment	Yield strength R _e N/mm ²		Tensile strength R _m N/mm ²		Elongation (L ₀ =5d ₀)		Impact work ISO-V KV J		
	MPa		MPa		%		+ 20 °C – 40 °C		
As Welded	490		560		30		160 55		
Operating data									
			Polarity DCEP		Note: * metal recovery rate may vary slightly with higher diameter Re-drying if necessary : 300 – 350°C min. 2h				
Approvals									
ABS, LR, DNV-GL, BKI, CE									
Size, Packaging and Electrical Operating Data									
Size (mm)		Carton Pack		Vacuum Pack		Amperage (A)			
∅	Length	Kg / Pack	Kg / Box	Kg /Vac.	Kg / Box				
2.50	350	5.0	20.0	2.0	12.0	80 – 110			
3.25	350 / 450	5.0	20.0	2.0	12.0	100 – 145			
4.00	350 / 400 / 450	5.0	20.0	2.0	12.0	140 – 200			
5.00	450	5.0	20.0	2.0	12.0	190 – 250			