

Classifications

AWS A5.1	EN ISO 2560-B	GB/T 5117
E7018-1H4R	E4918-1A	E 5018-1

Characteristics and typical fields of application

- Basic covered electrode with very good welding characteristics including out of position work.
- Weld metal recovery about 120%.
- Crack-free weld metal when welding high-carbon steels.
- Suitable for use in tank construction, boiler making, apparatus engineer, vehicle manufacture and shipbuilding.

Base materials

S235JRG2-S355J2, E295, E355, C35; boiler steels P235GH,P265GH,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-X60; cast steel GS-38, GS-45, GS-52; ageing resistant steels ASt 35-ASt 52.

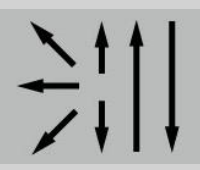
Typical analysis of all-weld metal

	C	Si	Mn	P	S					
wt-%	0.08	0.55	1.4	0.015	0.010					

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

Condition	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	- 45 °C
AW	480 (≥420)	590 (≥500)	30(≥22)	190(≥47)	110(≥47)

Operating data

	Polarity:	Re-drying if necessary:	ø mm
	DC +	250-350 °C,	2.5
		min. 2 h	3.2
			4.0
			5.0

Approvals

ABS,DNV-GL,BV,LR,CWB,CE