

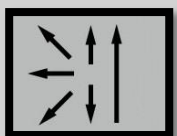
Classification				
AWS A5.1	AWS A5.1M	EN ISO 2560-A	EN ISO 2560-B	IS 814
E7018-1 H4R	E4918-1R	E 42 5B 4 2 H5	E 49 18 A H5	EB 56 26 H3 JX

Characteristics and field of use
<ul style="list-style-type: none"> ▪ Basic covered electrode with very good welding characteristics including out of position work ▪ Good impact properties down to -45°C ▪ CTOD tested at -10 °C and shows good resistance crack propagation. ▪ Diffusible Hydrogen level < 4ml /100 gm. weld metal ▪ Crack-free weld metal when welding high carbon steels ▪ Suitable for Sour Service application (HIC & SSCC tested according to NACE) ▪ "Dry System" (vacuum packing)

Base Materials
235JRG2-S355J2, E295, E335, C35, Boiler Steels P235GH,P265 GH, P295GH,P355GH; fine graine structural steels upto S420N; shipbuilding steels A,B,D,E; offshore steels;pipe steels P265, P295,L290NB-L415NB, L290MB- L415MB, API 5L Gr. X42-X46; cast steels GS-38,GS-45,GS-52; ageing resistant steels ASt35 - ASt52; pressure vessel steels SA516 Gr. 60,65,70, SA 106 Gr. B

Typical Composition of all weld metal (wt. - %)							
C	Si	Mn	S	P	Cr	Mo	Ni
0.070	0.50	1.30	0.010	0.015	0.008	0.007	0.006

Mechanical Properties of all weld				
Heat treatment (PWHT), °C/Hr	Yield strength R _e N/mm ²	Tensile strength R _m N/mm ²	Elongation (L ₀ =4d ₀)	Impact Test Values @ -45°C
	MPa	MPa	%	J
As Welded	470	580	30	90

Operating data					
Position	Polarity	Re-drying conditions:	Ø(mm)	L	Amps
	DCEP	Applicable only for electrodes exposed to the environment, prior to welding redrying at 250-350 °C for 2-3 Hrs recommended.	2.50	350	70 -110
			3.15	350/450	100-140
			4.00	450	130-180
			5.00	450	180-230
Size & Packaging (Dry system)		Size	Kg./Pack	Kg./Box	
		2.50x350	2.0	18.0	
		3.15x350/450	2.0	18.0	
		4.00x450	2.0	18.0	
		5.00x450	2.0	18.0	