



Application/properties:

Low hydrogen basic electrode that has good weldability and the weld obtained from it has good mechanical properties, especially good toughness at low temperatures, and is resistant to cracking due to its high toughness at low temperatures. This electrode is used for welding high strength steels used at low temperatures. The weld of this electrode has a greater penetration depth than that of E۸۰۱۸. The arc obtained from this electrode is stable and focused during welding. It also has good quality in terms of radiographic testing.

Weld metal analysis in % (typical values):

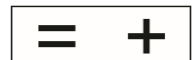
C	Mn	Si	P	S	Ni
۰.۰۶	۰.۹	۰.۳۵	< ۰.۰۲	< ۰.۰۲	۱.۶

Mechanical Properties of all-weld metal: (single values are typical values)

Heat treatment	Tensile Strength (N/mm ^۲)	Yield Strength (N/mm ^۲)	Elongation A۵ (%)	Impact energy (J) ISO-V
				-۵۰°C
AW	۵۷۰	> ۴۶۰	> ۲۳	> ۱۰۰

AW :As weld

Welding Parameters		
Diameter (mm)	Length (mm)	Amperage (A)
۲.۵	۳۵۰	۶۵ - ۹۵
۳.۲۵	۳۵۰ - ۴۵۰	۹۰ - ۱۳۰
۴.۰	۳۵۰ - ۴۵۰	۱۴۰ - ۱۸۵
۵.۰	۴۵۰	۱۸۰ - ۲۴۵



Remarks:

- Just Consume Dry Electrode
- Rebaking: required on ۳۰۰°C to ۳۵۰°C for ۲ hours.