



E 55 4 Mn1NiMo B T 42 H5

Basic electrode used for welding fine-grained structural steels with high strength. Weld metal is extremely metallurgical pure having very low hydrogen content. The electrode has a stable and concentrated arc, thus being well-suited for positional welding. Welds are of X-ray quality.

C	Mn	Si	Mo	Ni	S	P
0.06	0.6	0.4	0.3	0.6	< 0.02	< 0.02

Heat treatment	Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation A ₅ (%)	Impact energy (J)
				ISO-V -20 °C
T	720	> 550	> 22	120

Welding Parameters		
Diameter (mm)	Length (mm)	Amperage (A)
2.0	30+	70 - 90
3.25	40+	90-140
4.0	40+	140 - 180
5.0	40+	180 - 240



DIN Standard	STE ٣٢٠ to STE ٥٠٠; WSTE ٣٥٥ to WSTE ٥٠٠; TSTE ٣٢٠ to TSTE ٥٠٠; ١٧MnMoV ٩ ٣; ١٥NiCuMoNb ٥; ٢٠MnMoNi ٣ ٥;
EN Standard	S٣٢٠N to S٥٠٠N; S٣٥٥NL to S٥٠٠NL; P٣٥٥NL١ to P٣٤٠NL١; P٣٥٥NH to P٥٠٠NH.
ASTM Standard	ASTM A٥١٧ Gr. A, B, C, E, F, H, J, K, M, P. A٣٢٥ Gr. C; A٣٣٣ Gr. E; A٥٧٢ Gr. ٣٥

- Required at 175°C to 225°C for 1 hour
- Preheating, inter pass temperature and post weld heat treatment in accordance with base metal to be welded.