

**Application/properties:**

Basic electrode used for welding fine-grained structural steels with high strength. Its weld metal has excellent toughness due to the presence of nickel and is very resistant at low temperatures. 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.

Weld metal analysis in % (typical values):

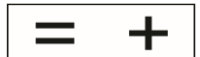
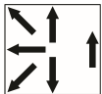
C	Mn	Si	Mo	Ni	S	P
۰.۰۶	۱.۱	۰.۳	۰.۴۵	۰.۱	< ۰.۰۲	< ۰.۰۲

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

Heat treatment	Tensile Strength (N/mm ^۲)	Yield Strength (N/mm ^۲)	Elongation A _۵ (%)	Impact energy (J) ISO-V
				-۴۰°C
AW	۵۸۰-۶۶۰	> ۵۰۰	> ۲۲	۱۰۰

AW: As weld

Welding Parameters		
Diameter (mm)	Length (mm)	Amperage (A)
۲.۵	۳۵۰	۶۵ - ۹۰
۳.۲۵	۴۵۰	۹۰ - ۱۳۰
۴.۰	۴۵۰	۱۴۰ - ۱۸۰
۵.۰	۴۵۰	۱۹۰ - ۲۳۰

**Rebaking:**

- Required at ۳۰۰°C to ۳۵۰°C for ۲ hours
- Preheating, inter pass temperature and post weld heat treatment in accordance with base metal to be welded.