

**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):

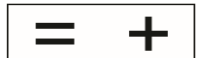
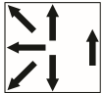
C	Mn	Si	Mo	Ni
٠.٠٦	١.١	٠.٤	٠.٣٢	١.٩

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

Heat treatment	Tensile Strength (N/mm ^٢)	Yield Strength (N/mm ^٢)	Elongation A _٥ (%)	Impact energy (J) ISO-V
				-٣٠°C
T	٥٨٠-٦٦٠	> ٥٠٠	> ٢٢	١٠٠

T : Tempered ٢٠٥°C /١h

Welding Parameters		
Diameter (mm)	Length (mm)	Amperage (A)
٢.٥	٣٥٠	٦٥ - ٩٠
٣.٢٥	٤٥٠	٩٠ - ١٣٠
٤.٠	٤٥٠	١٤٠ - ١٨٠
٥.٠	٤٥٠	١٩٠ - ٢٣٠

**Remarks:**

- Just Consume Dry Electrode
- Rebaking: required on ٣٠٠°C to ٣٥٠°C for ٢ hours.