

Basic universal electrode for welding highly stressed steel assemblies (carbon and carbon manganese, tensile strength up to 560 MPa). It's mechanical properties are excellent, especially at low temperatures.

## Classification

EN ISO 2560-A : E 42 4 B 4 2 H5  
AWS A 5.1 : E 7018-1

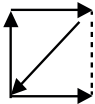
## Applications

- Pipework,
- Pressurised tanks,
- Shipyards,
- Offshore oil platforms,
- High quality steel constructions.

## Benefits

- Excellent mechanical properties.
- Low hydrogen concentration.

## Positions and polarity



- Ignition from 70V - Direct current.
- **Electrode polarity : (+) for thin sheets/penetration and (-) for filling.**

## Chemical properties

C %	Mn %	Si %	S %	P %
0.05	1.40	0.40	0.020	0.015

## Mechanical properties

Re	Rm	A 5 d	KV -40 °C
470 MPa	560 MPa	26%	60 J

## Recommendations





Ø électrode (mm)	2.0	2.5	3.2	4.0
thickness (mm)	1,5 ▶ 3	2,5 ▶ 6	5 ▶ 8	8 ▶ +
welding current (A)	20 ▶ 50	60 ▶ 110	90 ▶ 140	130 ▶ 190

## Approval

TÜV - RINA - ABS - LRS - DNV



## Packaging

		 (2 kg) SOUS VIDE	Ø (mm)	length (mm)	 →  X...
A	066717		Ø 2.0	300	13
A	066724		Ø 2.5	350	10
B	081918		Ø 2.5	350	210
B	081970	84			
A	066731		Ø 3.2	350	7
B	081925		Ø 3.2	350	130
B	081987	54			
A	066748		Ø 4.0	350	6
B	081932		Ø 4.0	350	96
B	081994	38			