



Welding Electrode with excellent toughness properties

CLASSIFICATION :	EN ISO 2560-A	AWS A/SFA 5.1	IS 814
	E 42 3 B 32	E 7018-1	E B5529H ₃ JX

KEY FEATURES :

- Basic type iron powder electrode
- All position capability including vertical down position
- Excellent toughness down to -46°C
- Suitable for pipe welding in 5G & 6G position
- Radiographic quality weld

WELDING POSITION : AC (70 OCV)/ DCEP

TYPICAL APPLICATIONS :

- Storage tanks, Pressure vessels
- Boilers, Bridges, Pipes
- Heavy structures subject to dynamic loading and mechanical restraint
- Suitable for ASTM SA 414/414M Gr.C/D, SA 516/516M Gr.55/60, IS 2002, IS 2062 steels

REDRYING CONDITION : 300°C for 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.06	1.1	0.35	0.02	0.02
Specification	0.04-0.09	0.80-1.60	0.20-0.45	0.03 max.	0.03 max.

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -46°C, J
Typical	As Welded	575	490	26	42
Specification		520-640	450-540	24 min.	30-50

Hardness, 3 Layers: 200 BHN max.

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg
2.5 x 350	60-90	5	4	20
3.15 x 450	90-140	5	4	20
4.0 x 450	140-180	5	4	20
5.0 x 450	180-230	5	4	20