

Welding low alloy high strength steels**CLASSIFICATION**

EN ISO 18275-A (E 69 4 Mn2NiCrMo B 42)
A5.5 (E 10018-G)

GENERAL DESCRIPTION

Low hydrogen electrode for welding quenched and tempered or micro alloyed steels.
The Charpy V impact strength is high, also at sub zero temperatures.
It has an excellent welder appeal thanks to its double coating. This coating is moisture resistant.

TYPICAL USE

Welding of T1 steel, HY80, NAXTRA65,70, Superelso, Superelso 700.
For boilers, tanks, dredging equipment, construction,- excavating-, mining equipment.
Welding of high strength rails.
Repair on forklifts.
Heavy machinery.

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C	Mn	Si	Cr	Ni	Mo	P & S
0.03 - 0.10	1.40 - 2.00	< 0.60	0.30 - 0.60	1.80 - 2.60	0.30 - 0.60	< 0.020

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 690 MPa	760-960 MPa	≥ 18%	≥ 47 J (-40°C)

General information

- Welding positions:** All
- Shielding gas:** NA
- Dia (x length) (mm):** 2.5 - 3.2 (x 350) / 4.0 - 5.0 (x 450)
- Packing:** 5 kg in cardboard box
- Polarity:** DC, reverse polarity (electrode positive) - for root pass use straight polarity
- Tips & tricks:** Clean weld area. Weld with a short arc.
Use stringer beads and avoid weaving for the highest mechanical characteristics.
If required, dry the electrodes at 250-300 °C (480-570 °F) for 2 hours (use Lastidry).

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.