

Covered electrode

Classification: ASME / AWS A5.1 E7018
EN ISO 2560-A-E 42 3 B

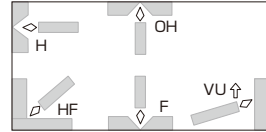
Features: • Suitable for butt and fillet welding of heavy structure
• Good performance by DC-EP current

Type of covering: Iron powder low hydrogen

Redrying Conditions: 300~350°Cx0.5~1h

Identification color: 1st Blue white, 2nd Blue

Welding Positions:



Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S
Example	0.07	0.59	0.97	0.013	0.007
Guaranty	0.05~0.10	≤0.75	≤1.60	≤0.020	≤0.020

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°Cxh)
Example	500	560	31	-29°C:110	AW
	420	520	32	-29°C:140	620x1
Guaranty	≥400	≥480	≥22	-29°C≥27	AW
	≥350	≥460	≥25	-29°C≥27	620±15x1

Recommended welding parameters

	2.6mm	3.2mm	4.0mm	5.0mm
Dia.	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H	65~95A	90~130A	130~190A	190~250A
VU, OH	60~90A	80~120A	110~170A	165~210A

Polarity

Example	AC
Guaranty	AC, DC-EP

Approvals

ABS	LR	DNV	NK
3Y H10	3Ym H15	3YH10	KMW53H10

Packages

Dia. (mm)	Length (mm)	Weight per pack(kg)	Weight per carton(kg)	Weight per piece(g)
2.6	350	5	20	24
3.2	400	5	20	41
4.0	450	5	20	69
5.0	450	5	20	106