



Classification : AWS A5.5 : E10018-G

EN 757 : E 62 5 1,5NiMo B 42

Properties & Applications :

High-cracking basic electrode developed for welding fine-grained steels and for all steels generally with high mechanical characteristics (Rm up to 800 MPa). High-security assembly used as a bond layer in the case of hard reloading. Pleasant fusion, stable arc, low projections, good detachment of the slag and beautiful appearance of the cord.

Weldable steel materials :

General steel constructions materials :	
NF A 35-501	A50-2* . A60-2* ,3. E36-2* ,3* ,4*.
DIN 17100	St50-2* . St60-2* . St70-2* .
ASTM :	A 678grC* . A709gr50* ,100* . A710gr A.
Steel with high elastic limitations	
NF A 36-204 :	E500T* .E550T* .E620T* . E690T* .
DIN 17102	StE460, 500* ,590* ,690* .
Can also be used for welding steels for thermal treatments such as : 15CD4* .25CD4* .35CD4* .XC38 .XC48* .32C4. . , As well as for certain steel constructions for self-smoothing types (please ask for more info if needed).	

(*) with eventually pre and post heating in case of high layers.

Analyse of type of deposited steel (%) :

C	Si	Mn	Cr	Ni	Mo
<0.10	0.5	1.4	0.2	1.5	0.4

Mechanical Characteristics of the deposited steel :

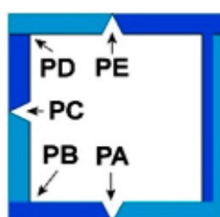
Re (MPa)	Rm (MPa)	A ₅ (%)	KV (J)
>620	720-820	>22	+20° C > 130 -20° C > 90 -50° C > 50

Average Intensity & Conditions of use :

Electrode	øxL (mm)	2,5x350	3,2x350	4,0x450	5,0x450
Intensity	(A)	80	115	150	190

Steaming the electrodes at 350°C for 2 hours. Preheating depending on the thickness and nature of the sheet metal (100°C). Temperature between passes 200 degrees Celsius. In most cases, heat treatment and holding is recommended at 600°C for 2 hours.

Welding position :



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