



Classification : AWSA5.1 : E7018-1 / AWSA5.1M : E4918-H8 / EN 499 : E 46 4 B 32 H5 / ISO 2560-A : E 46 4 B 32 H5

Properties & Applications :

Universal basic electrode (return 115%) providing great security for any high-demand or bridled assembly. Excellent resilience up to -50°C, good resistance to cold cracking, easy to remove dairy. For chassis, heavy frames, ship building, pressure machines

Weldable steel materials :

General-purpose construction steels, naval plates, boiler steels and pressure, High-Limit Steels elastic, Ch-resistant steels, Cold-resistant steels		
EN-Designation	S185 - S355	P235 - P355
	GP240R	P235GH - P265GH
	L210 - L360	
Maritim sheets	Quality A, B, C, et D	
ASTM	A285 grade C	A414 grade C, D, E, F
	A442 grade 55,60	A515 grade 55, 60, 65, 70
	A516 grade 55, 60, 65, 70	

Analyse of the type of deposited steel (%) :

C	Si	Mn	P	S
<0.10	0.5	1.3	<0.025	<0.025

Mechanical characteristics of the deposited steel :

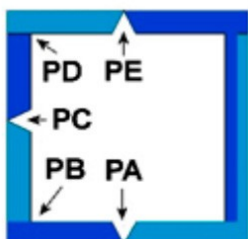
Re (MPa)	Rm (MPa)	A ₅ (%)	KV (J)
>420	510-610	>24	+20° C > 160 -20° C > 100 -40° C > 47

Average intensity & Conditions of use :

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

Heating process: 2 h at 300°C if necessary / interpasses temperatures < 250°C

Welding positions



Responsibility: The purpose of this document is to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for the applications for which it is intended. We reserve the right to modify the characteristics of its products without notice. Descriptions, illustrations and features are provided as an indication and cannot be the responsibility of our company. Smoke: View information on the Security Data Sheet available on request