

Carbon Manganese Steel Electrode - Low Hydrogen Type

CLASSIFICATION :

AWS A/ SFA 5.1
E 7018IS 814
E B5426H₃JXEN ISO 2560-A
E 42 2 B 32 H5

KEY FEATURES :

- Basic type iron powder electrode
- Metal recovery approx. 115%
- Radiographic weld deposit
- Suitable for heavy structural work

TYPICAL APPLICATIONS :

- Joining steel of ASTM SA 414/414M
Gr.C/D, SA 516/516M Gr.55/60, 2002, IS 2062
- Storage tanks
- Pressure vessels, Pipes
- Bridges, Heavy structures

WELDING POSITION :



POLARITY : AC/DCEN/DCEP

REDRYING CONDITION : If electrodes are exposed re-bake at 300°C for 1 hour prior to use

TYPICAL WELDMETAL CHEMISTRY :

Elements	C %	Mn %	Si %	S %	P %
Typical	0.06	1.00	0.50	0.03	0.02
Specification	0.40 - 0.90	0.80 - 1.60	0.35 - 0.70	0.03 Max	0.03 Max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS, MPa	Elongation, %	CVN Impact, J	
					-20°C	-30°C
Typical	As Welded	540	470	25	55	45
Specification		500 - 600	440 - 550	24 - 30	50 - 80	30 - 70

Diffusible Hydrogen Content: <5 ml/100 gm

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs / Packet	Packets / Box	Approx. wt of Packet	Approx. wt of Box
2.50 x 350	60 - 90	113	12	2.50 Kg	30.00 Kg
3.15 x 450	90 - 130	56	8	2.50 Kg	20.00 Kg
4.00 x 450	140 - 180	37	8	2.50 Kg	20.00 Kg
5.00 x 450	180 - 240	25	8	2.50 Kg	20.00 Kg