

4370 Kb

CATEGORY	SMAW Stick Electrodes
TYPE	Basic coated electrode for dissimilar welding and bufferlayers
APPLICATIONS	Joining steels with difficult weldability, high plasticity and therefore very well suitable for buffer layers before hardfacing and welding dissimilar steels..
PROPERTIES	Excellent weldability and scale and corrosion resistant up to 900°C. Extreme high elongation and impact values makes this electrode a excellent choice for critical welding applications.

CLASSIFICATION	AWS	A 5.4: E 307-15
	EN ISO	3581-A: E 18 8 Mn B 22
	DIN: W.Nr.	1.4370
	DIN	8556: E 18 8 Mn B 20+

SUITABLE FOR	Screening steels Tools steels* Low alloyed steels * Austenitic steels with Mn : type Z 120 M 12 Spring steels : 45S7*, 51S7*; 56SC7*, 45C4*, manganese steels, X120Mn12, 1.3401, C45, dissimilar joint welding between steel and stainless steel such as: Armor plate, high carbon steels. Recommended for welding rails, crossing, crusher teeth, hammers and applications where rolling wear is required.
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APPROVALS	CE approved
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WELDING POSITIONS:



WELD DEPOSIT WEIGHT %	C	Mn	Si	Cr	Ni	Mo	Fe
	<0.15	5-7	0.7	17-18	7-9	-	Rem

MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness HB
	AW	>350	>550	>37	20°C: >75, -40°C: , -60°C:	200-400*

*strain hardening

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters			Packing		
	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000	
2.5	300	60-90	2.4	14.4		
3.2	350	80-110	2.6	15.6		
4.0	350	100-150	2.8	16.8		
5.0	350/450	150-200	3.2	19.2		

REDRYING TEMPERATURE	300°C/2hr (not often required).
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