

Basic coated electrode producing weld metal resistant to atmospheric corrosion, used for welding similar weathering steels such as Patinax or Cor-ten. Tough weld metal, suited for joining thicker plate sections. Due to its double coating (up to 3,2 mm) this electrode has a stable and concentrated arc, making it suitable for positional welding. Welds are of X-ray quality.

| Classification | |
|----------------|--------------------------|
| AWS | A5.5: E7018-G-H4 |
| EN | 499: E 42 4 Z B 42 H5 |
| EN ISO | 2560-A: E 42 4 Z B 42 H5 |

| Approvals | Grades |
|-----------|--------|
| DB | |
| TÜV | |

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

| C | Mn | Si | P | S | Cr | Ni | Mo | Nb | V | N | Cu |
|------|----|------|---------|---------|----|----|----|----|---|---|------|
| 0.06 | 1 | 0.40 | ≤ 0.020 | ≤ 0.015 | - | 1 | - | - | - | - | 0.45 |

All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength N/mm ² | Tensile Strength N/mm ² | Elongation A5 (%) | Impact Energy ISO - V (J) - 40 °C | Hardness |
|----------------|-------------------------------------|---------------------------------------|----------------------|---|----------|
| As Welded | ≥ 420 | 500-600 | ≥ 25 | ≥ 100 | - |

Materials

S235J0W; S235J2W; S355J0W; S355J2W; S355K2W

Storage and redrying

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 340-360 °C for 2 hours, 5 times max.

HD ≤ 10: Re-dry at 300-350 °C for 2 hours, 5 times max

Current condition and welding position

DC+



Packaging data

| Diameter (mm) | Length (mm) | Current (A) | Electrode average weight (g) | Weld metal weight per electrode (g) |
|------------------|----------------|----------------|---------------------------------|--|
| 2,5 | 350 | 65-95 | 20,3 | 12,8 |
| 3,2 | 350 | 90-140 | 34,2 | 22,2 |
| 4,0 | 450 | 140-185 | 68,4 | 45,2 |
| 5,0 | 450 | 180-200 | 106,4 | 64,0 |