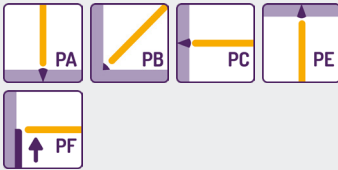


Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Application

General purpose basic electrode with medium-fine drop transfer and excellent welding properties for joint welding of unalloyed and low-alloyed steel in engineering, steel and boiler construction and ship building. It is especially suitable for fixed position welding. It is also suitable for steels with higher phosphor, sulfur and carbon content because of high ability for desoxidation and the low gas content of the weld metal. The special coating provides for low moisture absorption (LMA type).

Field



Characteristic

**basic-coated,
110 % recovery**

Standards

**ISO 2560-A
E 42 2 B 42 H10**

**AWS A 5.1
E 7018**

Approvals



Materials	
Construction steels	S235 - S355
Fine-Grained steels	S275 - S420
Ship steels	A32/36, D32/36, E32/36, F32/36, A/D
Boiler steels	P195 - P355
Pipe steels	L210 - L360
Cast steels	GE200, GE240, GP240, G20Mn5, G21Mn5
Reinforcing steels	BSt 420, BSt 500

All Weld Metal Mechanical Properties	
Heat Treatment	AW
Weld Metal Composition [%]	
C	Si
0,08	0,5
Mn	1,0
Yield Strength Re [MPa]	> 450
Tensile Strength Rm [MPa]	540-590
Elongation A5 [%]	> 27
Charpy Impact Value ISO-V [J/-20°C]	> 90

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.100.202	2,00/250	70 - 90	1,6	153	10,5
00.100.253	2,50/350	80 - 110	4,6	200	23,0
00.100.323	3,25/350	110 - 140	4,5	115	39,1
00.100.324	3,25/450	110 - 140	6,0	118	50,8
00.100.403	4,00/350	140 - 180	5,0	93	53,8
00.100.404	4,00/450	140 - 180	6,0	88	68,2
00.100.504	5,00/450	170 - 220	6,0	57	105,3
00.100.604	6,00/450	210 - 260	6,0	40	150,0



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