

BASOWELD 55

Electrodes MMA [SMAW]

Construction, unalloyed steels

CLASSIFICATION: EN ISO 2560-A : E 46 6 B 31 H5 DIN 8529 : EY 46 76 MnB AWS A-5.1 : E 7018-1	APPROVALS: UDT	APPLICATION: Power generation industry Constructions & Engineering Metallurgy (Steelworks) Mining Shipbuilding&Offshore
<ul style="list-style-type: none"> • Basic coated, low hydrogen. • Recommended for welding steels with tensile strength up to 680 MPa, working in extremely low temperature, in -60°C. • Especially recommended for welding construction steels dynamically loaded. 		



Base material

	EN
Construction steels:	S235-S355
Boiler plates:	P235GH-P355GH
Pipe steels:	P235-P355N
Shipbuilding plates:	A, B, D, E, AH32-EH36
Finegrained steels:	S275-S420, S460

Typical chemical composition %

C	Si	Mn
0,07	0,30	1,50

Typical mechanical properties

Yield strength Re [N/mm²]	>460
Tensile strength Rm [N/mm²]	530-680
Elongation A5 [%]	>20
Impact energy Kv [J]	>47J (-60°C) /
Coating type	basic
Hydrogen content	<5 ml/100 g
Welding current	
Welding positions	
Redrying	300 - 350°C / 2 h

Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,5	350 /	65-90	4,0	12,0	44
3,2	350 / 450 /	110-140	4,0/5,5	12,0/16,5	20

4,0	450 /	140-180	5,5	16,5	14
5,0	450 /	180-230	5,5	16,5	9

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