BASOWELD S

Electrodes MMA [SMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 2560-A : E 42 3 B 12 H10 DIN 1913 : E 51 43 B (R) 10 AWS A-5.1 : E 7016	UDT DNV: 4YH10	Power generation industry Constructions & Engineering Metallurgy (Steelworks) Mining Shipbuilding&Offshore

- Weldability of a Rutile Electrode with the Mechanical Properties of a Basic Electrode
- Versatile Dual-Coated Electrode – "2 in 1"
- Recommended for welding pipelines and steel structures.
- Ensures easy welding with smooth and clean weld beads.
- The dual coating provides a stable, concentrated, and direct arc, making it ideal for full penetration welds and welding in constrained positions.
- Enables precise control of the weld pool.
- High wettability even at low current settings.
- The dual coating minimizes arc deflection.
- Delivers high-quality welds, confirmed by ultrasonic and radiographic testing.
- Particularly suitable for root pass welding on pipes, without the need for side weaving.
- Produces smooth root penetration with self-releasing slag.
- Excellent for rebuilding worn or damaged components, especially in constrained positions.
- Facilitates easy joint formation, even with large root gaps.
- Enables trouble-free deposition of root layers on pipes, even in cases of significant misalignment.
- Allows relatively easy welding on rusted materials.

Application

Very easy operation makes it possible to perform excellent quality root passes as well as perfect fillet welds (all kinds of pipelines, load-bearing structures, repairs in various industries).

Base material

W.Nr	DIN	EN/CEN
1.0035 do 1.0570	St 33 to St 52-3	S185 to S355J2
1.0461 do 1.0562	StE 255 to P355N	StE 255 to P355N
1.0462 do 1.0565	WStE 255 to WStE 355	WStE 255 to P355NH
1.0345	St 35.8	P235GH
1.0425	St 45-8	P265GH
1.0481	17Mn4	P295GH
1.0308 do 1.0581	St 35 to St 52.4	E235 to P355N
1.0307 do 1.0582	StE 210.7 to StE 360.7	1.037 to L360NB
1.0440		S235JRS1
1.0472	21MnSi5	1.0472
1.0475		S235J2S1 GL-D
1.0476		S235J4S, GL-E
1.0416 do 1.0551	C18D to S355JRC	C18D to S355JRC
Shipbuilding steels A, B, D, AH32 to EH 36		
Non-alloy steels		
Boiler steels		
Pipes		
Fine-grained steels		

Typical chemical composition %

C	Si	Mn
0,06	0,55	0,75

Typical mechanical properties

Yield strength Re [N/mm2]	>420
Tensile strength Rm [N/mm2]	500-640
Elongation A5 [%]	>22
Impact energy Kv [J]	>47J (-20°C) / >47J (-30°C) / >47J (-40°C) - acc. to IACS standard /
Coating type	Double coated rutile-basic
Welding current	
Welding positions	
Redrying	380° / 1h or 300 - 350°C / 2 h
Additional description	Root pass with DC - Filling layers with DC+

Welding parameters and packing

ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,0	300 /	55-65	1,0	6,0	
2,5	350 /	60-110	4,5	13,5	50
3,2	350 / 450 /	80-140	4,3/5,5	12,9/16,5	30
4,0	350 / 450 /	140-190	5,5	16,5	15
5,0	450 /	190-250	5,5	16,5	9
		The welding current values provided in the table are approximate. In practice, depending on the type of material being welded, its thickness, welding conditions, and the welder's skill level, the actual values may differ from the specified range			

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