

BASOWELD Ni

Electrodes MMA [SMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 2560-A : E 50 6 1Ni B 42 H5 DIN 8529 : EY 50 75 Mn1 NiB AWS A-5.5 : E 8018-G		Power generation industry Constructions & Engineering

- Basic, low hydrogen electrode with Ni.
- Recommended for welding steels and steel castings with tensile strength up to 685 MPa and finegrained steels with yield strength up to 460 MPa.
- Mechanical properties are guaranteed at low temperatures.

Base material

	DIN	W.Nr
Unalloyed steels:	St 52.3 to St 70.2	1.0570 to 1.0070
Finegrained steels:	StE 380 to StE 460	1.8900 to 1.8905
	WStE 380 to WStE 460	1.8930 to 1.8935
Finegrained microalloyed steels:	TStE 380 to TStE 460	1.8910 to 1.8915
Ni alloyed steels:	13MnNi63, 15MnNi63	1.6217, 1.6210
Boiler plates:	17Mn4, 19Mn5	1.0481, 1.0482
Steel castings:	GS-52, GS-60	1.0551, 1.0553
Weather corrosion resistant steels:	CORTEN, Patinax	

Typical chemical composition %

C	Si	Mn	Ni
0,06	0,40	1,4	0,6-1,2

Typical mechanical properties

Yield strength Re [N/mm2]	>500
Tensile strength Rm [N/mm2]	570-720
Elongation A5 [%]	>22
Impact energy Kv [J]	>47J (-60°C) /
Coating type	basic
Hydrogen content	<4 ml/100 g
Welding current	
Welding positions	
Redrying	400°C / 1h

Welding parameters and packing

Ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]
2,5	350 /	65-90	4,0	12,0
3,2	350 /	110-140	4,0	12,0
4,0	450 /	140-180	5,5	16,5

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