

BASOWELD NiMoMn

Electrodes MMA [SMAW]

Low alloyed steel

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 18275-A : E 55 5 Mn 1 NiMo B 42 AWS A-5.5 : E 9018-G		Power generation industry Constructions & Engineering

- Basic coated welding electrode, Mn, Ni and Mo alloyed.
- Very good welding characteristics, stable and smooth arc, slag easy to remove, almost no spatter.
- It combines excellent mechanical properties down to -50°C as well as good toughness up to 450°C.

Base material

Unalloyed steels:	StE355-StE500, WStE355-WStE500, EStE355-EStE500
High tensile steels:	TStE500
Creep resistant steels:	17MnMoV64, 15NiCuMoNb5, 11NiMoV53, 20MnMoNi45

Typical chemical composition %

C	Si	Mn	Ni	Mo
0,07	0,55	1,50	1,0	0,45

Typical mechanical properties

Yield strength Re [N/mm²]	>550
Tensile strength Rm [N/mm²]	>650
Elongation A5 [%]	>20
Impact energy Kv [J]	>47J (-50°C) /
Coating type	basic
Hydrogen content	<5 ml/100 g
Welding current	
Welding positions	
Redrying	300 - 350°C / 2h

Welding parameters and packing

ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]
2,5	350 /	65-95	4,0	12,0
3,2	450 /	100-140	5,5	16,5
4,0	450 /	130-190	5,5	16,5

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl