

BASOWELD 690

Electrodes MMA [SMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 18275-A : E 69 6 Mn2NiCrMo B 42 H5 AWS A-5.5 : E 11018-G		Steel construction yards

- An electrode with a basic coating containing Ni, Cr, and Mo additives, designed for welding fine-grained steels with high strength and yield strength up to 690 N/mm², such as St E 550 V W. No. 1.8926 and St E 690 V W. No. 1.8928, as well as for welding armored and special steels.

Application

Used for various construction applications, including self-propelled cranes, concrete pumps, pipelines, mining equipment, tankers and containers, railway transportation, vehicle chassis, and special machinery.

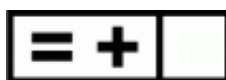
Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo
0,07	0,40	1,4	0,40	2,0	0,40

Typical mechanical properties

Yield strength Re [N/mm²]	>690
Tensile strength Rm [N/mm²]	780 - 940
Elongation A5 [%]	>17
Impact energy Kv [J]	>47J (-60°C) /
Coating type	basic

Welding current



Welding positions



Welding parameters and packing

Ø	Length [mm]	Welding current [A]
3,2	350 /	80-150
4,0	450 /	140-190

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