

BASOWELD 50

Electrodes MMA [SMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 2560-A : E 42 4 B 32 H5 AWS A-5.1 : E 7018	UDT: E 42 4 B 31 H5 TUV (07358): E 42 4 B 32 H5 DB-Zul Nr 10.151.01: E 42 4 B 32 H5 BV, DNV, PRS: 3YH5 LR: 3YmH5	Power generation industry Constructions & Engineering Metallurgy (Steelworks) Mining Petrochemical and chemical industry Shipbuilding&Offshore

- Basic coated, low hydrogen electrode with recovery about 120% and excellent welding parameters, recommended for welding unalloyed and low alloyed steels with tensile strength up to 600 MPa, static and dynamic loaded.
- Recommended especially for welding in difficult positions.
- Coating of the electrode is more resistant for the atmospheric moisture, and so recommended for shipbuilding and field working conditions.
- The focused and stable arc allows good control of the weld pool during welding.

Application

Shipbuilding industry, dynamically loaded structures, constructions steels, pipes, truck sides, bridges.

Base material

W.Nr	DIN	CEN
1.0035	St 33	S185
1.0114	St 37-3 U	S235J0
1.0143	St 44-3 U	S275J0
1.0553	St 52-3 U	S355J0
		L210 -L455
1.0429	StE 290.7 TM	L290MB
1.0578	StE 360.7 T	L360MB
1.0254	St 37.0	P235T1
1.0255	St 37.4	P235T2
1.0256	St 44.0	P275T1
1.0257	St 44.4	P275T2
		S275N-S420N
1.0345	St 35.8	P235GH
1.0425	St 45-8	P265GH
1.0481	17Mn4	P295GH
1.0473	19Mn6	P355GH
		S235JR-S355JR, P215NL, P265NL S275ML-S420ML, L245MB-L415MB
		S235JO-S355JO, P285NH-P420NH P275NL1-P355NL1, GE200-GE240
		S235J2-S355J2, P195TR1-P265TR1 P275NL2-P355NL2, GE300

		L415NB
Shipbuilding steels A, B, D, E, A32-F36; A40-F40		S275M-S420M, P195TR2-P265TR2
Other not specified boiler steels, pipes, fine grain steels, castings, cold drawn steels		S275NLS420NL, L245NB-
St3SX, St3S, St3W, St4Vy, St4W, 18G2A		

Typical chemical composition %

C	Si	Mn
0,08	0,60	1,00

Typical mechanical properties

Yield strength Re [N/mm2]	>420
Tensile strength Rm [N/mm2]	500-640
Elongation A5 [%]	>20
Impact energy Kv [J]	>47J (-40°C) / >47J (-20°C) /
Coating type	basic
Hydrogen content	<5 ml/100 g, typ. 3,5 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]	Pcs/1 kg
2,0	300 /	50-60	2,1	12,6	76-77
2,5	350 /	65-90	4,5	13,5	42-43
3,2	350 / 450 /	110-140	4,3/5,5	12,9/16,5	26/20
4,0	350 / 450 /	140-180	4,0/5,5	12,0/16,5	20/15
5,0	450 /	180-220	5,5	16,5	9
6,0	450 /	240-290	5,5	16,5	

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