

BASOWELD SW

Electrodes MMA [SMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 2560-A : E 42 4 B 42 H10 AWS A-5.1 : E 7018	UDT, TUV	Power generation industry Constructions & Engineering Metallurgy (Steelworks) Mining Shipbuilding&Offshore

- Thanks to the dual rutile-basic cover, it maintains very high mechanical parameters, including guaranteed impact energy at -40 ° C, with very good welding parameters, similar to rutile electrodes.
- Increased weld metal recovery results in an efficiency of approx. 120%.
- Strong, concentrated arc, very good weld flow.
- Thanks to the high flexibility of the arch and the possibilities of welding worked elements, it is recommended for renovation work and welding in difficult mounting conditions.
- Welding possibility of both DC (+) and DC (-), as well as AC, also with small welding machines.

Application

Repair and assembly works, welding of structures and pipelines

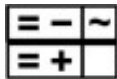

Base material

	DIN
Construction steels:	S235-S355
Boiler plates:	P235GH-P355GH
Pipe steels:	P235-P355N
Shipbuilding plates:	A, B, D

Typical chemical composition %

C	Si	Mn
0,07	0,50	0,90

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) /
Coating type	Double coated rutile-basic
Welding current	 <small>Pzetaup/ Root pass Wygwień/ Filling</small>
Welding positions	
Redrying	300-350°C / 2h

Welding parameters and packing

Ø	Length [mm]	Welding	Weight of	Weight of	Pcs/1 kg
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		current [A]	packet [kg]	carton [kg]	
2,5	350 /	60-90	4,5	18,0	47
3,2	350 / 450 /	90-140	4,5/5,5	18,0/22,0	27/21
4,0	450 /	140-190	5,5	22,0	14
5,0	450 /	190-240	5,5	22,0	9

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