

BASOWELD 60

Electrodes MMA [SMAW]

Low alloyed steel

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 2560-A : E 50 4 Mo B 42 H5 DIN 8529 : EY 50 75 Mn1 Mo B AWS A-5.5 : E 8018-G		Constructions & Engineering Metallurgy (Steelworks) Mining Shipbuilding&Offshore

- Low hydrogen basic coated electrode with Mn and Mo.
- For welding steel and cast steel with a tensile strength of up to 700 N/mm² and fine grain steels with a yield strength of 500 N/mm².

Base material

	DIN
Unalloyed steels:	St44.2, St70.2
Finegrained steels:	StE 255 to StE 500, WStE 255 to WStE 500
Boiler plates:	HI, HII, 17Mn4, 19Mn5
Ageing resistant steels:	ASt41, ASt45, ASt52
Pipe steels:	St35-St52.4
Shipbuilding plates:	A-E, AH32-EH36
Steel castings:	GS38-GS60

Typical chemical composition %

C	Si	Mn	Mo
0,07	0,45	1,30	0,35

Typical mechanical properties

Yield strength Re [N/mm2]	>500
Tensile strength Rm [N/mm2]	620-720
Elongation A5 [%]	>22
Impact energy Kv [J]	>47J (-40°C) /
Coating type	basic
Welding current	
Welding positions	
Redrying	400°C / 1h or 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 /	65-90	4,0	12,0
3,2	350 /	110-140	4,0	12,0

4,0	450 /	140-180	5,4	16,2
5,0	450 /	180-230	5,4	16,2

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