

BASOWELD 50**CLASSIFICATION:**

EN ISO 2560-A: E 42 4 B 32 H5

AWS A-5.1: E 7018

APPROVALS:

UDT: E 42 4 B 31 H5

TUV (07358), DB-Zul Nr 10.151.01/01: E 42 4 B 32 H5
BV, DNV-GL, LR, PRS: 3YH5**DESCRIPTION:**

- 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	W.Nr	DIN
1.0035	St 33	1.0255	St 37.4
1.0114	St 37-3 U	1.0256	St 44.0
1.0143	St 44-3 U	1.0257	St 44.4
1.0553	St 52-3 U		
		1.0345	St 35.8
1.0429	StE 290.7 TM	1.0425	St 45-8
1.0578	StE 360.7 T	1.0481	17Mn4
1.0254	St 37.0	1.0473	19Mn6

and others

TYPICAL CHEMICAL COMPOSITION (%):

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

TYPICAL MECHANICAL PROPERTIES:**Re:** >420 N/mm²**Rm:** 500-640 N/mm²**A5:** >20%**Kv:** >47J (-40°C)

>47J (-20°C)

Coating: basic**Redrying:** 300 - 350°C / 2h**Hydrogen content:** <5 ml/100 g, typ. 3,5 ml/100 g

Welding parameters			Packing		
φ	Length [mm]	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	

Read more about this product: <https://www.metalweld.pl/en/basoweld-50>