

**BASOWELD 55 - EVB 55p****CLASSIFICATION:**

EN ISO 2560-A: E 46 6 B 31 H5

DIN 8529: EY 46 76 MnB

AWS A-5.1: E 7018-1

**APPROVALS:**

UDT

**DESCRIPTION:**

- Basic coated, low hydrogen.
- Recommended for welding steels with tensile strength up to 680 MPa, working in extremely low temperature, in -60°C.
- Especially recommended for welding construction steels dynamically loaded.

**BASE MATERIAL:**

	EN
Construction steels	S235-S355
Boiler plates	P235GH-P355GH
Pipe steels	P235-P355N
Shipbuilding plates	A, B, D, E, AH32-EH36
Finegrained steels	S275-S420, S460

**TYPICAL CHEMICAL COMPOSITION (%):**

C 0,07 Si 0,30 Mn 1,50

**TYPICAL MECHANICAL PROPERTIES:****Re:** >460 N/mm<sup>2</sup>**Rm:** 530-680 N/mm<sup>2</sup>**A5:** >20%**Kv:** >47J (-60°C)**Coating:** basic**Redrying:** 300 - 350°C / 2h**Hydrogen content:** <5 ml/100 g

φ	Welding parameters		Packing		
	Length [mm]	Current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,5	350	65-90	4,0	12,0	44
3,2	350/450	110-140	4,0/5,5	12,0/16,5	20
4,0	450	140-180	5,5	16,5	14
5,0	450	180-230	5,5	16,5	9