

BASOWELD 60**ELECTRODES**
(SMAW)**CLASSIFICATION:**

EN ISO 2560-A: E 504 Mo B 42 H5
 DIN 8529: EY 50 75 Mn1 Mo B
 AWS A-5.5: E 8018-G

DESCRIPTION:

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

TYPICAL MECHANICAL PROPERTIES:

Re: >500 N/mm²
 Rm: 620-720 N/mm²
 A5: >22%
 Kv: >47J (-40°C)

Coating: basic
 Redrying: 400°C / 1h or 300-350°C / 2h



φ	Welding parameters		Packing	
	Length [mm]	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

SMAW electrodes for low alloyed, medium alloyed and high strength steels