

ESAB 36H

ESAB 36H is a basic coated, hydrogen controlled iron powder electrode designed for welding in all positions. It gives tough and crack resistant weld on mild and low alloy steels. ESAB 36H deposits good radiographic quality welds and is ideal for welding restrained structures where stresses cannot be avoided.

Specifications	
Classifications	SFA/AWS A5.1 : E7018 EN ISO 2560-A : E 42 3 B 32 H5
Approvals	ABS : 3YH5 BV : 3Y HH CE : EN 13479 DNV : 3YH15 IBR : E7018 IRS : 3Y HH LR : 3YmH15 PDIL : E7018 M N Dastur : EB5426H3JX

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	C-Mn
Coating Type	Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	470 MPa	550 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS		
As Welded	-30 °C	100 J
As Welded	-40 °C	80 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.08	1.20	0.40

Deposition Data	
Diameter	Current
2.5 x 350.0 mm	60-100 A
3.15 x 450.0 mm	80-130 A
4.0 x 450.0 mm	100-190 A
5.0 x 450.0 mm	180-260 A