

LOW ALLOY
STICK ELECTRODES (SMAW)

This electrode is tailored for steels with very high tensile strength. The electrode gives tensile strength over 900 N/mm² and impact values over 47 J at -60 °C.

Specifications

Classifications	EN ISO 18275-A : E 89 6 Z B 32 H5
Welding Current	AC, DC+
Diffusible Hydrogen	<5.0 ml/100g
Alloy Type	CrNiMo
Coating Type	Basic

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	922 MPa	974 MPa	19 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-60 °C	47 J

Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 350.0 mm	70-110 A	24 V	61 %	52 sec	0.9 kg/h
3.2 x 350.0 mm	110-150 A	24 V	63 %	77 sec	1.4 kg/h
4.0 x 450.0 mm	150-200 A	24 V	65 %	86 sec	1.9 kg/h