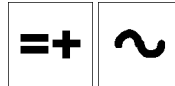


**Coating type:**

Basic

**Current:**



**Welding positions:**



Basic is our high quality low hydrogen ( $H_{DM} < 5 \text{ ml. / 100 gr. deposit weld metal}$ ) electrode for all welding positions, except vertical down position. This electrode is characterised by a smooth, quiet arc, very low spatter, an easy slag removal and good mechanical properties up to  $-50^{\circ}\text{C}$ . Typical applications include shipbuilding, general constructions and offshore constructions. Basic is welded on DC (+) current, has 120% recovery and is suitable to weld fine-grain steel grades.

**Base materials to be welded:**

- Ships plate A-E, A(H)32-E(H)36, S315G1S-S355G3S
- Structural steel S185-S355J2G3, St.33-St.52.3, C(K)10-C(K)35
- Boiler steel P235GH-P355GH, HI, HII, 17Mn4, 19Mn6
- Fine grain steel P275N-P355NL2, S275N-S420N, StE285-ESStE355, StE285TM-ESStE355TM
- Pipe steel P235T1-P355N, L210-L415MB, St37.0-St52.4, St45.8, X42-X60, StE210.7-StE360.7TM
- Cast steel GP240R, GS45

**Applications:**

- Shipbuilding & Offshore
- General fabrication & construction
- Power Generation
- Repair & Maintenance

**Chemical composition, wt. % weld metal – typical:**

C	Mn	Si	S	P
0,07	1,3	0,3	0,006	0,011

**Mechanical properties, weld metal – typical:**

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	$\geq 420$	$\geq 510$	$\geq 25$	-50°C $\geq 47$ 20°C $\geq 120$

**Packaging and welding data:**

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	21,0	65-110
3,2	350	39,1	100-145
4,0	450	72,5	135-200
5,0	450	103,6	180-280