

Classifications

EN ISO 2560-A:2006	: E 46 2 Z B 32 H10
EN ISO 2560-B:2006	: E 55 18-NCC1 A U H10
AWS A5.5-06	: E8018-W2

Description

- Covering is low hydrogen, iron powder type for welding of 560MPa class high tensile strength weathering type structural steel for buildings, bridges and other steel structures. (ASTM A67 Gr.1 ; A242 Gr.all ; A588 Gr.all ; A606 Gr.all ; A709 Gr.70W)
- Excellent weather-proof properties and crack resistance of the deposited weld metal.
- Good weldability and usability.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	Cu
0.05	0.47	0.70	0.015	0.015	0.69	0.54	0.01	0.45

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-30°C	
AWS A5.5	min. 460	min. 550	min. 19	≥ 27		
EN ISO 2560-A	min. 460	530-680	min. 20	≥ 47		
Example	530	590	24	80	60	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	400	400
Amp. (A)	F V · OH	70~110 60~90	90~130 70~110	150~190 120~160	180~230 130~170

Approvals

CE