

Meltolit

48 E

AWS A5.1: E 7018-H4R ISO 2560-A: E 42 5 B 42 H5

DESCRIPTION

Basic coated electrode for low- and unalloyed steel. Low hydrogen content with high mechanical properties. Root passes can be welded with DC-. Suitable for welding steel constructions, machine constructions, ships, containers, tanks, high strength pipe constructions etc.

WELDING POSITIONS



CURRENT

DC+

COATING

Basic

MATERIAL

Construction steel, pipework, shipping, pressure vessels

MECHANICAL PROPERTIES

Rm (Mpa)	Rp 0,2 (Mpa)	A5 (%)	KV(j)
560	>480	28	- 46°C: 80 - 50°C: 60

WELD METAL COMPOSITION(%)

C	Si	Mn		
0.06	0.50	1.20		

PACKAGING & WELDING PARAMETERS

48 E		2,5 x 350mm	3,2 x 450mm	4,0 x 450mm	
Item code		8M70182503	8M70183205	8M70184005	
48 E Vacuum	2,0 x 300mm	2,5 x 350mm	3,2 x 450mm	4,0 x 450mm	5,0 x 450mm
Art.nummer	8M70182006	8M70182506	8M70183206	8M70184006	8M70185005
Current(A)	40-80	70-110	80-145	120-210	200-285
Voltage (V)	23	23	24	25	25

EQUIVALENT FILLER METALS

TIG	Meltolit SG3
MAG	Meltolit SG2, SG3
FCW	Megafil 710M, Megafil 713R

Redrying if necessary for 2 hours in 300°C.