

	<b>TECHNICAL DESCRIPTION</b>	FT-DT.21.04
	<b>EUROTROD MC 36</b>	PAGE 29/29

**CERTIFIED COMPANY:**



**CLASSIFICATION:**

**AWS A5.5: E 8018 C1**

**DESCRIPTION:**

Basic type electrode for high-grained structural steels. Good weld ability in all positions. Low spatter loss. Easy slag removal. Regular seams, high crack resistance. Diameters up to 3,2 mm especially suitable for root passes in all welding positions except vertical-downward.

**SUITABLE FOR:**

TTSt 35 N, TTSt 35 V, 10 Ni 14			
TStE 255 TStE 420			

**TYPICAL CHARACTERISTICS OF ALL-WELD METAL:**

**Chemical Analysis (%):**

C	Si	Mn	Ni	P	S		
0,07	0,45	0,70	2,05	< 0,02	< 0,02		

**Mechanical Properties:**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation 4d (%)	CHARPY V (J)	
			-60 °C	
>470	>550	>25	>30	

**PRODUCT INFORMATION:**

WELDING PARAMETERS				PACKING DATA	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces/ Packet (Un)	Weight/ Packet (kg)
2,5	350	65 – 95	DC	220	4,5
3,2	450	100 – 140	DC	140	6,0
4,0	450	130 – 190	DC	95	6,4
5,0	450	180 – 240	DC	60	6,3

**WELDING POSITIONS:**

