	TECHNICAL DESCRIPTION	FT-DT.03.09
	EUROTROD BN 18	PAGE 16/16

CERTIFIED COMPANY:



CLASSIFICATION:

AWS A5.1: E 7018.1 H4
EN ISO 2560-A-E 42 4 B 4 2 H 5

DESCRIPTION:

Basic type electrode with 110% recovery. Suitable for highly crack-resistant, tough joints and some low alloy steels. Welding without pore formation.

SUITABLE FOR:

St 33 to St 52.3	St 37.4 to St 52.4	StE 210.7 TM to StE 360.7 TM	TStE 255 to TStE 355
St 50.2 to St 60.2	St 35.8 to 17 Mn 4	StE 255 to StE 355	A, B, D, E
H I, H II, 17 Mn 4	StE 210.7 to StE 360.7	WStE 255 to WStE 355	GS-38 to GS-52

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:

Chemical Analysis (%):

C	Si	Mn	P	S			
0,07	0,45	1,35	< 0,02	< 0,02			

Mechanical Properties:

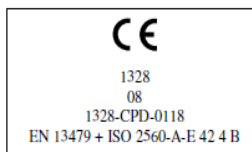
Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 5d (%)	CHARPY V (J)	
			-46°C	
>450	>500	>22	>47	

PRODUCT INFORMATION:

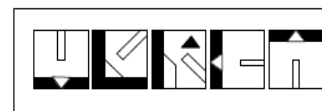
WELDING PARAMETERS				PACKING DATA		VACUUM PACKING	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces /Packet (Un)	Weight /Packet (kg)	Pieces /Packet (Un)	Weight /Packet (kg)
2,0	350	40 – 60	DC	330	4,8	140	2,1
2,5	350	60 – 90	DC	210	4,7	80	1,8
3,2	350	90 – 140	DC	140	4,8	55	1,8
3,2	450	90 – 140	DC	140	6,0	55	2,4
4,0	350	140 – 190	DC	95	5,0	35	1,8
4,0	450	140 – 190	DC	95	6,4	35	2,4
5,0	450	180 – 240	DC	60	6,3	25	2,6
6,0	450	240 – 300	DC	40	6,5	20	3,3

APPROVALS:

- I.S.Q. (Welding Institute of Quality): Cert. Nº 09/1298
- Lloyd's Register of Shipping: Cert. Nº LIS 0900023
- Bureau Veritas / Rinave: Cert. Nº 09.L.2451
- G.L. (Germanischer Lloyd): Cert. Nº WF 0960165HH
- DNV: Cert. Nº W-21791



WELDING POSITIONS:



DATE: 13-06-2009

Document: FT- DT.03.09.doc