


| | | |
|---|------------------------------|-------------|
|  | 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:

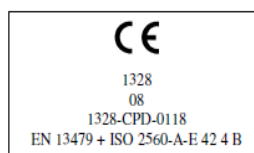
| Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Elongation 5d (%) | CHARPY V (J) | |
|--|--|----------------------|--------------|--|
| | | | -46°C | |
| >450 | >500 | >22 | >47 | |

PRODUCT INFORMATION:

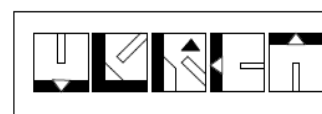
| WELDING PARAMETERS | | | | PACKING DATA | | VACUUM PACKING | |
|--------------------|----------------|----------------------------|--------------------------|------------------------|------------------------|------------------------|------------------------|
| Diameter (mm) | Length (mm) | Recommended 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: 13-05-2009

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