



Signed by P-O Oskarsson	Approved by Rune Pedersen/Barbro Karlström	Reg no EN002917	Cancelling EN002257	Reg date 2005-05-27	Page 1 (2)
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## REASON FOR ISSUE

Dimension range updated

## GENERAL

Cu-Ni-alloyed MMA electrode for welding weathering steels, e g Cor-Ten steel.

**Min AC OCV:** 65

**Polarity:** AC, DC (+)

**Alloy Type:** Weathering steel

**Coating Type:** Lime Basic

## WELDING POSITIONS



## CLASSIFICATIONS Electrode

EN 499	E 46 5 Z B 32
SFA/AWS A5.5	E8018-G
ISO 2560	E51 5 B 120 26 H

## APPROVALS

ABS	3H5, 3Y
BV	3Y HH
DB	10.039.20
DNV	3 YH10
DS	EN 499
GL	3YH15
LR	3, 3Y H15
RS	3YHH
Sepros	UNA 485154
SFS	EN 499
SS	EN 499
UDT	EN 499
VdTÜV	02115
Ü	10.039/1

## CHEMICAL COMPOSITION

	All Weld Metal (%)	
	Min	Max
C	0.02	0.10
Si	0.15	0.55
Mn	0.75	1.25
P		0.020
S		0.020
Ni	0.50	0.90
Cu	0.30	0.50



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## MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal			
	ISO		AWS	
	Min	Typ	Min	Typ
Rp0.2 (MPa)	460	500	460	500
Rm (MPa)	550	590	550	590
A4-A5 (%)	22	27	19	27
Charpy V at -20°C (J)	54	160		
Charpy V at -40°C (J)	47	130		
Charpy V at -50°C (J)	47	70		

## ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U
	Min	Max							
2.0 x 300	60	90	1.4	125	0.62	113.0	0.7	42	20
2.5 x 350	80	115	2.6	125	0.62	66.0	0.90	59	21
3.2 x 350	100	150	3.7	119	0.62	43	1.2	68	23
3.2 x 450	100	150	4.9	120	0.66	30.5	1.30	90	22
4.0 x 450	130	200	7.3	120	0.68	20.0	1.80	100	23
5.0 x 450	190	280	10.6	115	0.70	13.5	2.60	106	27
6.0 x 450	240	370	15.4	115	0.68	9.5	3.30	115	28

- W** = Weight (kg / 100 electrodes)  
**η** = Efficiency (g weld metal x 100 / g core wire)  
**N** = Effective value (kg weld metal / kg electrodes)  
**B** = Changes (number of electrodes / kg weld metal)  
**H** = Deposit rate at 90% of max current (kg weld metal / hour arc time)  
**T** = Fusion time at 90% of max current (s / electrode)  
**U** = Arc voltage (V)