



Manual metal arc electrode

EutecTrode® 35256

For non or low alloyed Steels

Description

Manual electrode with thick basic coating (Metal recovery 110 %) for high grade and crack resistant joints of low alloy steels. The basic coating constituents ensure a high purity of the welding pool, which promote particularly good mechanical properties of the deposit, especially regarding the toughness at temperatures lower than 0°C. The melting of the electrode ensures a smooth, metal transfer resulting in little spatter formation. The slag is easy to remove revealing fine regular beads. The special arcing tip makes it easy to strike the electrode and weld in all positions except in vertical down.

Temperature in service between -50°C and +450°C.

Technical data

Standards

ISO 2560-A: E 42 5 B 4 2 H5

AWS A5.1: E 7018-1H4R

Mechanical Properties (as-welded)

	Minimum	Typical
Tensile strength (N/mm ²):.....	500	560
Yield strength (N/mm ²):.....	420	460
Elongation A5 (%):.....	20	27
Impact strength A _v ISO-V (- 50°) (J):.....	47	70

Approvals

TÜV, DB, CE

Applications

High integrity crack resistant, welds on standard steel construction, boiler, plates, pipes, machine construction, vehicle construction and shipbuilding as well as for buffer layers on builds ups on high carbon steels.

Suitable for joining different base materials:

S235, S275, S355, S420

P195, P215, P235, P265, P275, P285, P355, P420

L245, L415

GE200, GE240, GE300

Shipbuilding: A, B, D, E, A 32-F36, A 40-F 40

Seamless pipes: ASTM A-106 (Gr.: A, B, C), ASTM A-181 (Gr: 60,70), ASTM A-283 (Gr: A, C) , ASTM A-285 (Gr: A, B, C), ASTM A-350 (Gr: LF1, LF2), ASTM A-414 (Gr: A, B, C, D, E, F, G); ASTM A-501 (Gr : B); ASTM A-513 (Gr: 1018), ASTM A-516 (Gr: 55, 60, 65, 70), ASTM A-573 (Gr: 65, 68, 70), ASTM A-588 (Gr: A, B), ASTM A-633 (Gr: A, C, D, E), ASTM A-662 (Gr: A, B, C), ASTM A-707 (Gr: L1, L2, L3); ASTM A-711 (Gr: 1013), ASTM A-841 (Gr: A, B, C); API 5L (Gr: B, X42, X52, X56, X60)

Procedure for use

Preparation

Degrease and clean the area of the weld. Chamfer the joint in V, U or X according to the thickness of the parts to be welded, break the edges.

Welding

Maintain a short arc, electrode almost perpendicular to the joint.

Welding position

PA, PB, PC, PD, PE, PF according to ISO 06947.

Welding parameter

Welding current: **=(+)**

Ø Electrode (mm)	Welding current (A)
2.5	50-90
3.2	90-150
4.0	120-190

Storage and handling

Safely stack and store electrodes in a dry location to avoid humidity pick up or coating damage. Should electrodes become damp, the following re-drying conditions before use are recommended: 350°C / 2 hr.

Availability

Dimension Ø x l (mm)	Packaging (kg)	ESC code	Electrodes/pack
2.5 x 350	4,2	764204	190
3.2 x 350	4,2	764205	120
4.0 x 450	5,8	764206	90