

**CLASSIFICATIONS:**

**AWS A/SFA 5.5 E 13018-G**  
**BS E 611HJ**  
**IS E 83BG129Fe**  
**DIN EKb**

**CHARACTERISTICS:**

A medium heavy coated, hydrogen controlled low alloy high tensile steel electrode suitable for welding fully killed fine grain steel. The electrode works in all-position, gives very little spatter with an easily removable slag leaving a weld bead of nice appearance. The electrode gives radiographic quality weld in all-positions. Re-dry the electrode at 350°C for 2 hour for best results.

**TYPICAL APPLICATIONS:**

- For welding high tensile steel XABO-90 manufactured by M/sThyssen(HOAG).
- Penstocks, earthmoving equipment and other heavy steel fabrication made from high tensile steels.

**SPECIAL INSTRUCTIONS:**

- Use completely dry electrodes.
- Dry the electrodes in an oven at 350°C for two hours.
- Remove from the oven, at a time, electrodes that are sufficient for ten minutes of welding only.

**TYPICAL ALL WELD METAL CHEMICAL COMPOSITION:**

Element	C	Mn	Si	Cr	Ni	Mo	S	P
%	0.60-0.10	1.40-1.80	0.30-0.50	0.60-0.80	2.20-2.80	0.40-0.50	0.03 max	0.03max

**ALL WELD MECHANICAL PROPERTIES**

**N/mm<sup>2</sup>**

UTS 940-1040  
 YS 850-950  
 Elongation(%)(l=4xd) 15-21  
 CVN Impact Value 27±2(°C) 70-120J

**CURRENT CONDITIONS:**

SIZE mm		2.50 X 350	3.15 X 350	4.00 X 350	5.00 X 350
CURRENT-Amps	AC/DC(+)	60-90	90-140	140-180	180-250