

**CLASSIFICATIONS:**

AWS A/SFA 5.5 E 10018-M  
 IS E688M229Fe  
 BS E611HJ  
 DIN EKb

**CHARACTERISTICS:**

A hydrogen controlled low-alloy, high tensile steel electrodes suitable for welding flux killed fine grained steels. The electrode works in all positions, gives very little spatter, easily removable slag, leaving a bead of nice appearance. Gives radiographic quality welds. Deposition efficiency approximately 112%. Redry the electrodes at 350°C for 2Hrs to obtain best results.

**TYPICAL APPLICATIONS:**

- For welding high tensile steels, such as USST-1, HOAG N-A-XTRA 65, N-A-XTRA 70, BH65.
- Penstocks, earthmoving equipment and other heavy steel fabrications made from high tensile steels, etc.,

**TYPICAL ALL WELD METAL CHEMICAL COMPOSITION:**

Element	C	Mn	Si	Cr	Ni	Mo	S	P
%	0.05-0.10	1.30-1.80	0.25-0.60	0.40max	1.25-2.50	0.50max	0.03 max	0.03max

**ALL WELD MECHANICAL PROPERTIES**

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

UTS 760-840  
 YS 680-760  
 Elongation%(l=4xd) 20-25  
 Reduction in area 40-70%  
 CVN Impact Value -51°C 30-70J

**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