



EM150

Basic Covered Electrode - Fine Grained High Strength Steels

AWS/ASME SFA 5.5 E8018C3

Characteristics

Base Material



Heavy coated basic type electrode, suitable for welding steel constructions, off-shore platforms, bridge, machinery, production and in their root pass applications where low high strength steels and fine grained structural steels used. Weld metal is high crack resistance under difficult operating conditions such as dynamic loads and especially low environmental temperatures.



Typical Chemical Analysis	%C 0.05	%Mn 0.9	%Si 0.25	%S	%P
	%Cr	%Ni 0.9	%Mo	%Cu	%Ti

Mechanical Properties

	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elongation A5 %	Impact Energy J
Typical Results (all weld metal)				
As Welded	480 mpa	570 mpa	25	-60C 50 J

Ordering Information

Packing Information and Welding Current

Product Code	ØxLenght (mm)	Pieces / Box	Weight / Box (kgs)	Boxes / Outerbox	Weight / Outerbox (kgs)	Welding Current [A]
1151310M15	2.50x 350	245	5,0	3	15,0	60-90
1151316M15	3.25x 350	141	5,0	3	15,0	90-140
1151324M15	4.00x 450	99	6,5	3	19,5	130-180
1151332M15	5.00x 450	65	6,5	3	19,5	190-240

Storage and Drying Information

- 1-It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.
- 2-It has to be dried at 350°C for 2 hours.
- 3-It can be dried maximum 5 times.

