

	TECNHICAL DATA SHEET	FT-DQ09
	EUROTROD BN 18	PÁG. 1/1

CLASSIFICATION:

AWS A5.1: E 7018.1 H4
EN ISO 2560-A-E 42 4 B 4 2 H5

CERTIFIED COMPANY:

DESCRIPTION:

Basic type electrode with 110% recovery. Suitable for highly crack-resistant, tough joints and some low alloy steels. Welding without pore formation.

SUITABLE FOR:

St 33 to St 52.3	St 37.4 to St 52.4	StE 210.7 TM to StE 360.7 TM	TStE 255 to TStE 355
St 50.2 to St 60.2	St 35.8 to 17 Mn 4	StE 255 to StE 355	A, B, D, E
H I, H II, 17 Mn 4	StE 210.7 to StE 360.7	WStE 255 to WStE 355	GS-38 to GS-52

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:
Chemical Analysis (%):

C	Si	Mn	P	S			
0,07	0,45	1,35	< 0,02	< 0,02			

Mechanical Properties:

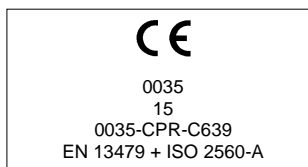
Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 5d (%)	CHARPY V (J)	
			-45°C	
>450	>500	>22	80	

PRODUCT INFORMATION:

WELDING PARAMETERS				PACKING DATA		VACUUM PACKING	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces /Packet (Un)	Weight /Packet (kg)	Pieces /Packet (Un)	Weight /Packet (kg)
2,0	350	40 – 60	DC	310	4,7	140	2,1
2,5	350	60 – 90	DC	190	4,4	75	1,7
3,2	350	90 – 140	DC	130	4,3	50	1,7
3,2	450	90 – 140	DC	130	5,7	50	2,2
4,0	350	140 – 190	DC	80	4,3	30	1,6
4,0	450	140 – 190	DC	80	5,5	30	2,1
5,0	450	180 – 240	DC	50	5,4	21	2,2

APPROVALS:

- Lloyd's Register of Shipping
- Rinave
- DNV
- VdTuv
- ABS
- RINA


WELDING POSITIONS:
