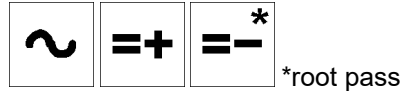


Coating type:
Basic-rutile

Current:



Welding positions:



Basic 55 is our double coated basic-rutile electrode for all welding positions, except vertical down position. This electrode is characterised by easy handling, a well controllable arc, excellent root penetration, easy slag removal and excellent metallurgical properties up to -30°C. Typical applications include shipbuilding, general constructions, bridges, storage tanks as well as root pass and positional welding. Basic 55 is an all-current type (AC/DC).

Base materials to be welded:

- Ships plate A-E, A(H)32-E(H)36, S315G1S-S355G3S
- Structural steel S185-S355J2G3, St.33-St.52.3, C(K)10-C(K)35
- Boiler steel P235GH-P355GH, HI, HII, 17Mn4, 19Mn6
- Fine grain steel P275N-P355NL2, S275N-S420N, StE285-EStE355, StE285TM-EStE355TM
- Pipe steel P235T1-P355N, L210-L415MB, St37.0- St52.4, St45.8, X42-X60, StE210.7-StE360.7TM
- Cast steel GP240R, GS45

Applications:

- Shipbuilding & Offshore
- General fabrication & construction
- Power Generation
- Repair & Maintenance

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P
0,06	0,90	0,70	≤ 0,025	≤ 0,025

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 400	≥ 490	≥ 22	-20°C ≥ 90

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	19,5	55-95
3,2	350	32,8	80-150
3,2	450	42,4	95-150
4,0	450	65,0	120-190