

	TECNICAL DATA SHEET	FT-DQ.19
	EUROTROD MC 40	PÁG. 1/1

CLASSIFICATION:

AWS A5.5: E 11018-G H4
EN ISO 18275: E 69 4 Mn2NiCrMo B 4 2 H5

CERTIFIED COMPANY:


Management
System
ISO 9001:2015



www.tuv.com
ID 1100008183

DESCRIPTION:

Basic type electrode for welding of steels with high strength (Rm up to 1080 Mpa). Good weld ability in all positions. Low spatter loss. Easy slag removal. Regular seams, high crack resistance.

SUITABLE FOR:

ESSt 460 to ESSt 690			
TStE 460 to TStE 690			

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

C	Si	Mn	Cr	Ni	Mo	P	S
0,07	0,60	1,50	0,50	1,85	0,45	< 0,02	< 0,02

Mechanical Properties:

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 4d (%)	CHARPY V (J)	
			-40°C	
>700	>800	>16	>47	

PRODUCT INFORMATION:

WELDING PARAMETERS				PACKING DATA	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces/ Packet (Un)	Weight/ Packet (kg)
2,5	350	65 – 95	DC	220	4,7
3,2	450	100 – 140	DC	140	6,0
4,0	450	130 – 190	DC	95	6,4
5,0	450	180 – 240	DC	60	6,3

WELDING POSITIONS:
