

EM 150

Basic Coated Electrode - Fine Grained-High Strength Steels

Standards

AWS/ASME SFA - 5.5	E8018-C3
EN ISO 2560 - A	E 46 6 1Ni B 42
TS EN ISO 2560 - A	E 46 6 1Ni B 42

Properties and Applications

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.

Approvals & Certificates

GOST TSE

Materials

Width	DIN
S255N - S460N	StE 255 - StE 460
S225NL	TTSt 35N
S255NL	TSIE 255
P310NB	TTSt 41

Typical Chemical Values of Weld Metal

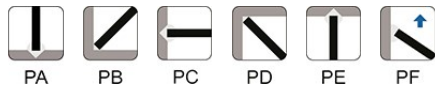
Type of Analysis	C	Si	Mn	Ni
Weld Deposit	0.04	0.20	1.10	1.00

Typical Mechanical Values of Weld Metal

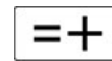
Test Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	530	600	25	-60°C → 60

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x350	60-90
3.25x350	90-140
4.00x450	130-180
5.00x450	190-240
6.00x450	260-320

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
12002HKEM2	2.50x350	120 pcs	2.54	6	15.50	VAC Box
12002HREM2	2.50x350	240 pcs	5.07	3	15.40	Cardboard Box
12002NKEM2	3.25x350	69 pcs	2.54	6	15.50	VAC Box
12002NREM2	3.25x350	138 pcs	5.07	3	15.40	Cardboard Box
12002SSEM2	4.00x450	99 pcs	6.58	3	19.90	Cardboard Box
12002VSEM2	5.00x450	62 pcs	6.58	3	19.90	Cardboard Box
12002XSEM2	6.00x450	43 pcs	6.58	3	19.90	Cardboard Box

Storage & Re-Drying Information

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