

EM 150W

Basic Coated Electrode - Weathering Steels

Standards

AWS/ASME SFA - 5.5	E8018-W2
EN ISO 2560 - A	E 50 6 Z 1Ni B 42
TS EN ISO 2560 - A	E 50 6 Z 1Ni B 42

Properties and Applications

Heavy coated basic type electrode, designed for welding weathering steels, like COR-TEN steels, high strength steels, particularly copper containing steels which are resistant to atmospheric corrosion. Due to its high crack resistance under difficult operating conditions such as dynamic loads, high and low environmental temperatures, suitable to use in fabrication of steel constructions like bridge, stadium, off-shore platforms. Easy to use in root and fill passes. Welds are of X-ray quality.

Approvals & Certificates

GOST

Materials

Width	DIN
S185 - S355J0	St 33 - St 52.3
E295	St 50.2
P235GH - P265GH	H I, H II
P295GH, P355GH	17Mn4, 19Mn5
P255TR2 - P355T2	St 37.4 - St 52.4
P235G1TH - P255G1TH	St 35.8 - St 45.8
L210 - L360NB	StE 210.7 - StE 360.7
S255N - S355N	StE 255 - StE 355
P255NH - P355NH	WStE 255 - WStE 355
S255NL1 - S355NL2	ESIE 255 - ESIE 355
S235JRW - S355J2W	WtSt 37.2 - WtSt 52.3

Typical Chemical Values of Weld Metal

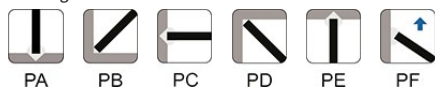
Type of Analysis	C	Si	Mn	CR	Ni	Cu
Weld Deposit	0.05	0.60	1.10	0.55	0.70	0.60

Typical Mechanical Values of Weld Metal

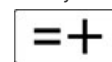
Test Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	580	690	22	-60°C → 55

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x350	60-90
3.25x350	90-140
3.25x450	100-140
4.00x450	130-180
5.00x450	190-240

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
12003HKEM2	2.50x350	125 pcs	2.54	6	15.50	VAC Box
12003HREM2	2.50x350	250 pcs	5.07	3	15.40	Cardboard Box
12003NKEM2	3.25x350	73 pcs	2.54	6	15.50	VAC Box
12003NREM2	3.25x350	147 pcs	5.07	3	15.40	Cardboard Box
12003SSEM2	4.00x450	96 pcs	6.58	3	19.90	Cardboard Box
12003VSEM2	5.00x450	64 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.