

EM 160

Basic Coated Electrode - Fine Grained-High Strength Steels

Standards

AWS/ASME SFA - 5.5	E8018-G H4
EN ISO 2560 - A	E 50 6 Mn1Ni B 42 H5
TS EN ISO 2560 - A	E 50 6 Mn1Ni B 42 H5

Properties and Applications

Heavy coated basic type electrode with high efficiency, which is for welding low alloy steels, fine grained structural steels and high strength pipes. Due to it's high crack resistance under difficult conditions such as dynamic loads and service temperatures between -60°C and 450°C, it is suitable for use in heavy steel structures, off-shore platform, heavy machinery, pressure vessels, tanks, boiler production, welding and repair jobs of pipes and in their root pass applications. Welds are of X-ray quality..

Approvals & Certificates

GOST

Materials

Width	DIN
P315N - P460N	StE 315 - StE 460
S380NL - S460NL	TSStE 380 - TSStE 460
P380NH - P460NH	WStE 380 - WStE 460

Typical Chemical Values of Weld Metal

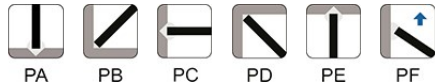
Type of Analysis	C	Si	Mn	Ni
Weld Deposit	0.07	0.60	1.75	0.85

Typical Mechanical Values of Weld Metal

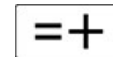
Test Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	600	680	22	-60°C → 55

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.00x300	45-60
2.50x350	60-90
3.25x350	90-140
4.00x450	150-180
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
12004HKEM2	2.50x350	111 pcs	2.54	6	15.50	VAC Box
12004HREM2	2.50x350	200 pcs	4.57	3	13.90	Cardboard Box
12004NKEM2	3.25x350	69 pcs	2.54	6	15.50	VAC Box
12004NREM2	3.25x350	124 pcs	4.57	3	13.90	Cardboard Box
12004SKEM2	4.00x450	38 pcs	2.56	6	15.60	VAC Box
12004SSEM2	4.00x450	98 pcs	6.58	3	19.90	Cardboard Box
12004VSEM2	5.00x450	61 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.