EM 176

Basic Coated Electrode - Fine Grained-High Strength Steels

Standards

AWS/ASME SFA - 5.5	E9018-G
EN ISO 18275 - A	E 62 6 Mn2NiMo B 42
TS EN ISO 18275 - A	E 62 6 Mn2NiMo B 42

Approvals & Certificates

TUV CE GOST

Materials

Width	DIN
S355N - S500N	StE 355 - StE 500

Properties and Applications

Heavy coated basic type electrode for welding fine grained and low alloy steels which will be subsequently normalized or normalized + tempered after welding. Weld deposit is tough and crack-free and has a low hydrogen content. Especially 2,50 mm and 3,25 mm diameters well suited for easy positional welding. Welds are of X-ray quality.

Typical Chemical Values of Weld Metal

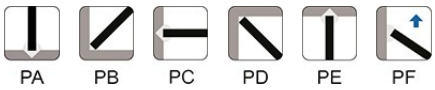
Type of Analysis	C	Si	Mn	Ni	Mo
Weld Deposit	0.05	0.30	1.60	2.00	0.40

Typical Mechanical Values of Weld Metal

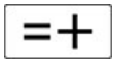
Test Condition	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	695	765	19	-60°C → 60

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

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

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
12010NREM2	3.25x350	132 pcs	4.57	3	13.90	Cardboard Box
12010SSEM2	4.00x450	96 pcs	6.58	3	19.90	Cardboard Box
12010VSEM2	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.