

# AS B-257 PIPE



## Basic Coated Electrode for Mild Steels

### Classification

EN ISO 2560-A : E 46 5 B 42 H5  
AWS A5.1 : E7018-1 H4

### General Description

AS B-255 is a basic coated electrode. Compared to the AS B-255, it allows for welding at lower currents thanks to its thinner cover diameter and special chemical changes made in its formula. This makes it possible to control easily weld pool by the welder when welding in position applications. The wetting capability of the weld metal is increased to ensure a good filling in the weld groove and to provide an excellent bead shape and profile. Weld metal has high impact strength at low temperatures. As the weld metal is very resistant to hot cracking, it is used particularly to weld rigidly restrained mass structures where high welding stresses are unavoidable. The slag is easy to remove and it gives very high quality, smooth weld beads. It has 115 % metal recovery.

### Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn
0.05	0.50	1.20

### Mechanical Properties, Typical, All Weld Metal

Yield Strength : 518 N/mm<sup>2</sup>  
Tensile Strength : 596 N/mm<sup>2</sup>  
Elongation (L=5d) : 27 %  
Impact (ISO-V) : 83 J (-50°C)

Redrying Temperature : 300-400°C / 2-3 hrs

### Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : DC (+) ; AC min 65 V

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
2.50	350	65 - 110	2263	2.0 / 90	5
3.25	350	95 - 145	3526	3.2 / 90	5
4.00	350	120 - 190	5300	4.8 / 90	6



1G/PA



2F/PB



2G/PC



4G/PE



3G/PF



5Gu/PH

**Liability** : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance. **Fumes** : Consult information on Welding Safety Sheet, available upon request.

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### Applications and Materials to be Welded

AS B-257 PIPE is especially designed for pipe welding applications. However, it provides excellent results in upward and overhead positions. It is suitable for fine grained structural steels having high yield strength values. It is designed for steel constructions and machines operating under dynamic forces at low temperatures. Welding of ship's plate of A-, D- and E- quality, boiler and pressure vessel manufacturing and pipe connections are among its application areas. AS B-255 PIPE can join steel parts to steel casts and can be used in the welding of thick parts. It is suitable for root passes and for welding in difficult positions. It gives excellent weld beads with high impact strength values at subzero temperatures.

	DIN	EN
<b>General Structural Steels</b>	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52 St 37-4, St 44-4, St 52-4 St 50-2, St 60-2, St 70-2 C 60, Ck 60	S185, S235, S275, S355 P235TR2 - P355T2 E295, E335, E360 C60
<b>Fine Grained Steels</b>	StE 255 - StE 420 WStE 255 - WStE 420 TStE 255 - TStE 420	S255N - S420N P255NH - P420NH S255NL - S420NL / P275NL1 - P355NL1
<b>Pipe Materials</b>	StE 210-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM - X42, X46, X52, X60 (API 5LX)	L210 - L360NB L290MB - L360MB L415NB -
<b>Boiler and Pressure Vessel Steels</b>	17 Mn 4, 19 Mn 6 Hl, Hll Hlll	P295GH, P355GH P235GH, P265GH, P285NH
<b>Elevated Temperature Steels</b>	St 35-8, St 45-8	P235G1TH - P255G1TH
<b>Ship Plates</b>	A, D, E AH32 - EH36	- -
<b>Cast Steels</b>	GS-38, GS-45, GS-52, GS-60, GS-70 GS-62	GE200, GE240, GE260, GE300, S355JOC -