

Basic Coated Electrode for Mild Steels

Classification

EN ISO 2560-A : E 46 4 B 32 H10
 AWS A5.1 : E7018

General Description

AS B-204 is a basic coated electrode. It is used particularly to weld rigidly restrained mass structures where high welding stresses are unavoidable. Weld metal has a high resistance to cracking. The slag is easy to remove and it gives very high quality, smooth weld beads. It has 125% metal recovery.

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

C	Si	Mn
0.06	0.50	1.20

Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 480 N/mm ²	
Tensile Strength	: 560 N/mm ²	
Elongation (L=5d)	: 30 %	
Impact (ISO-V)	: 110 J (-20°C)	Redrying Temperature : 250-400°C / 2-3 hrs
	: 80 J (-40°C)	

Approvals

CE, GOST, SEPRO, TSE

ABS	BV	GL	LRS	TL
3YH10, 3Y	3YH	3YH15	3m 3Ym H15	3YH

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : DC (+) ; AC min 70 V

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
2.00	300	50 - 80	1500	1.9 / 125	2
2.50	350	75 - 110	2390	4.8 / 200	5
3.25	350	110 - 150	3860	5.0 / 130	5
4.00	450	150 - 190	7260	6.2 / 85	6
5.00	450	170 - 240	10440	6.3 / 60	6



1G/PA

2F/PB

2G/PC

4G/PE

3G/PF

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Applications and Materials to be Welded

AS B-204 is suitable for steel constructions and machines operating under dynamic forces. Ship building, boiler and pressure vessel manufacturing and pipe connections are among its application areas. It is recommended for the welding of high carbon steels having high P and S content; welding of high strength ship's plate of A-, D- and E- quality and vessel plates of 17 Mn 4 and 19 Mn 5 type. AS B-204 is also suitable for welding thin plates in the small diameters.

	<u>DIN</u>	<u>EN</u>
General Structural Steels	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 C 22 - C 35 ; Ck 22 - Ck 35	S185, S235, S275, S355 P235TR2 - P355T2 E295, E335 C22 - C35
Fine Grained Steels	StE 255 - StE 420 WStE 255 - WStE 420 TStE 255 - TStE 420	S255N - S420N P255NH - P420NH S255NL - S420NL / P275NL1 - P355NL1
Pipe Materials	StE 210-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM X42, X46, X52, X60 (API 5LX)	L210 - L360NB L290MB - L360MB -
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 6 HI, HII HIII	P295GH, P355GH P235GH, P265GH, P285NH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, D, E AH32 - EH36	- -
Cast Steels	GS-38, GS-45, GS-52	GE200, GE240, GE260