

Basic Coated Electrode for Mild Steels

Classification

EN ISO 2560-A : E 42 2 B 11
 AWS A5.1 : E7048

General Description

AS B-235 is a basic coated electrode especially designed for welding in vertical downwards position, with a relatively large diameter electrode, at a very high travelling speed and high current. Thus, it can replace cellulosic coated electrodes in some circumstances. Weld metal has a high resistance to cracking.

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

C	Si	Mn
0.08	0.60	1.00

Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 460 N/mm ²	
Tensile Strength	: 560 N/mm ²	
Elongation (L=5d)	: 30 %	
Impact (ISO-V)	: 80 J (-20°C)	Redrying Temperature : 250-400°C / 2-3 hrs

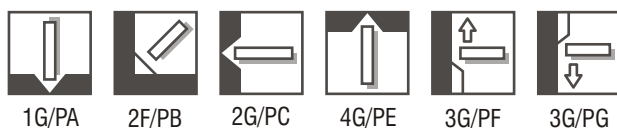
Approvals

GOST, SEPRO, TSE

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]
3.25	350	110 - 150	3020	5.1 / 170	5
4.00	350	140 - 200	4480	4.3 / 95	5





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Applications and Materials to be Welded

AS B-235 is especially 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; high strength ship's plate of A-, D- and E- quality and also for low alloyed and structural steels of similar strength with the electrode.

	DIN	EN
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	S185, S235, S275, S355 P235TR2 - P355T2 E295, E335
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 H1, H11 H111	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