

## Basic Coated Electrode for Mild Steels

### Classification

EN ISO 2560-A : E 46 6 B 22  
 AWS A5.1 : E7016-1

### General Description

AS B-268 is a basic coated electrode. It gives excellent quality, smooth and homogeneous weld beads with a very low impurity (like P and S) content. It guarantees a yield strength value up to 430 N/mm<sup>2</sup> for medium and high strength steels.

ø 2.5 or ø 3.25 mm electrode selection in the root pass brings homogeneous weld beads due to full penetration, which brings great advantage in special welding applications.

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

C	Si	Mn	P	S
0.07	0.50	1.10	< 0.03	< 0.03

### Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 460 N/mm <sup>2</sup>	
Tensile Strength	: 550 N/mm <sup>2</sup>	
Elongation (L=5d)	: 30 %	
Impact (ISO-V)	: 240 J (0°C)	Redrying Temperature : 250-400°C / 2-3 hrs
	240 J (-20°C)	
	180 J (-40°C)	
	120 J (-60°C)	

### Approvals

GOST, SEPRO, TSE

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

Current Type and Polarity : DC (+)

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	70 - 110	2080	4.2 / 200	5
3.25	350	100 - 140	3250	4.9 / 150	5
4.00	450	140 - 180	5940	6.5 / 110	6



1G/PA

2F/PB

2G/PC

4G/PE

3G/PF

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### Applications and Materials to be Welded

AS B-268 is designed 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, high strength low alloyed steels having high (P) and (S) content; 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-268 can join steel parts to steel casts and can be used in the welding of thick parts. It is suitable in the root pass and recommended especially in applications where high impact values are required at -30 or -40 °C.

	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 C 22 - C 35 ; Ck 22 - Ck 35	S185, S235, S275, S355 P235TR2 - P355T2 E295, E335 C22 - C35
<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 -
<b>Boiler and Pressure Vessel Steels</b>	17 Mn 4, 19 Mn 6 HI, HII HIII	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	GE200, GE240, GE260