



## Coated Electrode for High Strength Low Alloyed Steels

### Classification

EN ISO 2560-A : E 42 2 Z B 42  
 AWS A5.1 : E8018-G

### General Description

AS DA-708 is a heavily coated, Ni-Cu alloyed basic electrode. It gives a weld metal that has an excellent corrosion resistance to sea water and to flue gases. Weld metal has good mechanical properties. AS DA-708 welds with a quite, stable arc giving very little spatter.

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

C	Si	Mn	Ni	Cu
0.05	0.30	1.00	0.60	0.45

### Mechanical Properties, Typical, All Weld Metal

Yield Strength : 470 N/mm<sup>2</sup>  
 Tensile Strength : 570 N/mm<sup>2</sup>  
 Elongation (L=5d) : 28 %  
 Impact (ISO-V) : 120 J (-20°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	80 - 115	2320	4.6 / 200	5
3.25	350	100 - 140	3700	5.0 / 135	5
4.00	450	150 - 190	7040	5.6 / 80	6



1G/PA



2F/PB



2G/PC



4G/PE



3G/PF

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### Applications and Materials to be Welded

The electrode can be used in all positions for the welding of all types of joints. AS DA-708 is particularly designed for welding the shell platings of ships where the protective paint coating wears severely. Ship steels of A-, D- and E- quality and slow corrosion steels (due to its copper content) of the CORTEN-A and CORTEN-B type are among other application areas. It can be used in the welding of parts that work under dynamic loads at elevated temperatures; in all construction applications including bridges, boiler and pressure vessels, and shipbuilding. AS DA-708 can also be used in the root pass.

	<u>DIN</u>	<u>EN</u>
<b>General Structural Steels</b>	St 44, St 44-2, St 44-3, St 52-3 St 50-2, St 60-2, St 70-2	S275, S355 E295, E335, E360
<b>Fine Grained Steels</b>	StE 255 - StE 420 WStE 255 - WStE 420 TStE 255 - TStE 420 EStE 255 - EStE 355	S255N - S420N P255NH - P420NH S255NL - S420NL / P275NL1 - P355NL1 S255NL1 - S315NL1 / P275NL2 - P355NL2
<b>Pipe Materials</b>	StE 210-7 - StE 360-7	L245NB - L360NB
<b>Boiler and Pressure Vessel Steels</b>	17 Mn 4, 19 Mn 5 HI, HII, HIII	P295GH, P310GH P235GH, P265GH, P285NH
<b>Elevated Temperature Steels</b>	St 35-8, St 45-8	P235G1TH - P255G1TH
<b>Ship Plates</b>	A, D, E	—
<b>Weather Resisting Steels</b>	St 52-3 Cu3	S355 J2G3Cu S235 J0W, S235 J2W, S355 J0W S355 J2W, S355 K2G1W