

Coated Electrode for High Strength Low Alloyed Steels

Classification

EN ISO 2560-A : E 46 6 2 Ni B 42
 AWS A5.1 : E8018-C1

General Description

AS DA-710 is a heavily coated, Ni alloyed basic electrode. It is particularly useful for the welding of fine-grained steels and low alloy steels which have high impact resistance at low temperatures down to -60°C . It is used for the welding of joints which need to have high toughness values at low temperatures. It gives a weld metal that has an excellent corrosion resistance to sea water and to sulphuric acid fumes. It has about 120 % metal recovery.

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

C	Si	Mn	Ni	P	S
0.06	0.30	0.90	2.40	< 0.02	< 0.02

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 500 N/mm²
 Tensile Strength : 600 N/mm²
 Elongation (L=5d) : 28 %
 Impact (ISO-V) : 150 J (-20°C)
 110 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	80 - 115	2500	5.0 / 200	5
3.25	350	100 - 140	3740	5.1 / 135	5
4.00	450	140 - 190	7510	6.8 / 90	6



1G/PA



2F/PB



2G/PC



4G/PE



3G/PF

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Applications and Materials to be Welded

AS DA-710 is particularly designed for the welding of high strength low alloyed steels. It is suitable for the root pass and welding of pipelines and storage tanks that are frequently used in the chemical industry and cold storage areas.

	<u>DIN</u>	<u>EN</u>
General Structural Steels	St 52-3 St 60-2, St 70-2	S355 E335, E360
Fine Grained Steels	StE 255 - StE 500 WStE 255 - WStE 500 TStE 255 - TStE 500 EStE 255 - EStE 500 -	S255N - S500N P255NH - P500NH S255NL - S500NL / P275NL1 - P460NL1 S255NL1 - S500NL1 / P275NL2 - P460NL2 S355NH - S460NH
Pipe Materials	X52, X56, X60, X65 (API 5LX)	-
Low Temperature Steels	14 Ni 6, 16 Ni 14 TTSt 35 N, TTSt 45 N, TTSt 35 V, TTSt 45 V 10 Ni 14, 12 Ni 9, 14NiMn6 -	- - 12 Ni 14, X12 Ni 5, 15 NiMn 6 11 MnNi 5 3, 13 MnNi 6 3
Cast Steels	GS-52, GS-60	GE260, GE300