

Coated Electrode for High Strength Low Alloyed Steels

Classification

EN ISO 18275 : E 55 6 1NiMo B 42
 AWS A5.5 : E9018-G

General Description

DA-717 is a basic electrode. It is used for the welding fine-grained and high strength steels with a yield strength min. 600 N/mm². It gives a weld metal that has a high toughness value and resistant to cracking at low temperatures down to -60°C. It has 120 % metal recovery.

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

C	Si	Mn	Ni	Mo
0.04	0.30	1.00	1.10	0.35

Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 600 N/mm ²
Tensile Strength	: 650 N/mm ²
Elongation (L=5d)	: 23 %
Impact (ISO-V)	: 160 J (-30°C)
	70 J (-60°C)

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 - 120	2320	4.6 / 200	5
3.25	350	110 - 140	3710	5.0 / 135	5
4.00	450	140 - 190	7470	6.7 / 90	6



1G/PA



2F/PB



2G/PC



4G/PE



3G/PF



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Materials to be Welded

	<u>DIN</u>	<u>EN</u>
Fine Grained Steels	StE 420 - StE 500 WStE 420 - WStE 500 TStE 420 - TStE 500	S420N - S500N P420NH - P500NH S420NL - S500NL / P275NL1 - P460NL1
Pipe Materials	X60, X65, X70, X75, X80 (API 5LX)	–