

Coated Electrode for High Strength Low Alloyed Steels

Classification

EN ISO 3580 : E Mo R 22
AWS A5.5 : E8013-G

General Description

AS DA-731 is a rutile coated electrode. It gives a Mo alloyed weld metal that is used in the welding of boiler and pressure vessels operating under high temperatures.

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

C	Si	Mn	Mo
0.08	0.30	0.70	0.50

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 500 N/mm²
Tensile Strength : 600 N/mm²
Elongation (L=5d) : 24 %
Impact (ISO-V) : 50 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	75 - 110	2020	4.2 / 210	5
3.25	350	100 - 140	3380	5.1 / 150	5



1G/PA



2F/PB



2G/PC



4G/PE



3G/PF



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Applications and Materials to be Welded

AS DA-731 is used for the welding of low alloyed and pressure vessel steels with a tensile strength up to 540 N/mm². It is ideal for the welding of boiler and pressure vessel steels and pipe connections that operate under temperatures up to 525°C. AS DA-735, a basic coated electrode, should be preferred in multipass applications of thick sectioned or rigidly restrained mass structures.

	DIN	EN
Fine Grained Steels	StE 255 - StE 500	S255N - S500N
Boiler and	WStE 255 - WStE 500	P255NH - P420NH
Pipe Materials	StE 320-7 - StE 415-7 StE 360-7 TM - StE 415-7 TM X52, X56, X60 (API 5LX)	L320 - L415NB L360MB - L415MB -
Boiler and	HI, HII, HIII	P235GH, P265GH, P285NH
Pressure Vessel Steels	17 Mn 4, 19 Mn 5, 15 Mo 3 16 Mo 5	P295GH, P310GH, 16 Mo 3 -
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Cast Steels	GS-45 GS-22 Mo 4 GS-C 25	GE240 G20Mo5 GP240GH