

Coated Electrode for High Strength Low Alloyed Steels

Classification

EN ISO 3580 : E Mo B 22
AWS A5.5 : E7018-A1

General Description

AS DA-735 is a basic coated electrode. It gives a Mo alloyed weld metal that is used in the welding of boiler and pressure vessels operating under high temperatures. Ductile weld metal has a particular creep resistance. It is ideal in multipass applications that is required in the welding of thick and rigidly restrained mass structures. It gives high quality weld beads with good mechanical properties.

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

C	Si	Mn	Mo
0.08	0.30	0.80	0.50

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 510 N/mm²
Tensile Strength : 620 N/mm²
Elongation (L=5d) : 24 %
Impact (ISO-V) : 150 J (+20°C)

Approvals

GOST, SEPRO, TSE

TL

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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 - 110	2490	5.0 / 200	5
3.25	350	110 - 140	3840	5.2 / 135	5
4.00	450	150 - 190	7330	5.9 / 80	6



1G/PA



2F/PB



2G/PC



4G/PE



3G/PF

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Applications and Materials to be Welded

AS DA-735 is used for the welding of 15 Mo 3 grade steels operating under temperatures up to 550°C. It is also ideal for the welding of fine grained steels (up to St E480-7 TM). It is ideal for the welding of boiler and pressure vessel steels and pipe connections that operate under temperatures up to 525°C.

The stable arc enables proper welding in the root pass and in difficult positions.

	<u>DIN</u>	<u>EN</u>
Fine Grained Steels	StE 255 - StE 500 WStE 255 - WStE 500	S255N - S500N P255NH - P500NH
Pipe Materials	StE 320-7 - StE 415-7 StE 360-7 TM - StE 415-7 TM X52, X56, X60, X65 (API 5LX)	L320 - L415NB L360MB - L415MB -
Boiler and Pressure Vessel Steels	HI, HII, HIII 17 Mn 4, 19 Mn 5, 15 Mo 3 - 16 Mo 5	P235GH, P265GH, P285NH P295GH, P310GH, 16 Mo 3 P355GH -
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Cast Steels	GS-45, GS-52, GS-60 GS-22 Mo 4 GS-C 25	GE240 - GE300 G20Mo5 GP240GH
Steels Resistant to Aging	17 MnMoV 6 4, 15 NiCuMoNb 5 -	- 20 MnMoNi 4 5