

Coated Electrode for High Strength Low Alloyed Steels

Classification

EN ISO 3580 : E Mo B 22
AWS A5.5 : E 9018-D1

General Description

AS DA-737 is a basic coated, AC/DC electrode for the welding of high tensile strength steels. It gives a weld metal that has good notch toughness down to -60°C . Grain boundary cracking risk is very low.

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

C	Si	Mn	Mo
0.06	0.40	1.30	0.40

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 580 N/mm²
Tensile Strength : 660 N/mm²
Elongation (L=5d) : 24 %
Impact (ISO-V) : 170 J (+20°C)
50 J (-50°C)
40 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]
3.25	350	110 - 140	3790	4.6 / 120	5
4.00	450	150 - 190	7300	5.8 / 80	6
5.00	450	190 - 250	10500	6.3 / 60	6



1G/PA



2F/PB



2G/PC



4G/PE



3G/PF



Coated Electrode for High Strength Low Alloyed Steels

Applications and Materials to be Welded

Due to the weld metal's good notch toughness properties down to -60°C , it is used for welding unalloyed and low alloyed steel structures exposing to low temperatures like LPG holders. Welding of low alloyed high tensile steels when preheating cannot be applied and enclosed joint welding and cladding of rails when a hardness of about 250 HV is required are among its application areas.

	<u>DIN</u>	<u>EN</u>
General Structural Steels	St 50-2, St 60-2, St 70-2	E295, E335, E360
Fine Grained Steels	StE 380 - StE 500 WStE 380 - WStE 500	S380N - S500N P380NH - P500NH
Pipe Materials	X42, X46, X52, X56, X60, X65 (API 5LX)	-
Low Temperature Steels	TTSt 35 N, TTSt 35 V	-