

Coated Electrode for High Strength Low Alloyed Steels

Classification

EN ISO 18275 : E 69 5 Mn 2 NiCrMo BT 42
 AWS A5.5 : E11018-G

General Description

AS DA-753 is a basic coated electrode. It is used for the welding of fine-grained, heat treatable high strength steels with a yield strength up to 760 N/mm². It can also be used in the welding of fine grained structural steels having a yield strength value greater than 760 N/mm². It gives a weld metal that has a high toughness value and resistant to cracking at low temperatures down to -50°C.

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

C	Si	Mn	Cr	Ni	Mo
0.05	0.40	1.50	0.35	1.80	0.45

Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 700 N/mm ²
Tensile Strength	: 800 N/mm ²
Elongation (L=5d)	: 20 %
Impact (ISO-V)	: 115 J (+20°C)
	85 J (-20°C)
	70 J (-40°C)
	55 J (-50°C)
	40 J (-60°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	75 - 110	2290	4.6 / 200	5
3.25	350	100 - 145	3800	5.1 / 135	5
4.00	450	130 - 190	7390	5.9 / 80	6
5.00	450	180 - 250	11550	6.9 / 60	6



1G/PA



2F/PB



2G/PC



4G/PE



3G/PF

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Applications and Materials to be Welded

It is used for welding fine grained, low alloyed high strength structural steels at room temperature or with moderate preheat. It is used in the welding of steel structures, boiler and pressure vessels, and for construction of heavy machinery. It is particularly used in the root pass of high strength steels (790 N/mm²).

- 1) If possible, each joint should be welded continuously, except electrode change and slag removal.
- 2) In multi-pass welding applications, interpass temperature should be maintained at 100-150°C.
- 3) Use only dry electrodes.

	DIN	EN
Fine Grained Steels	StE 500 WStE 500 TStE 500 15 NiCrMo 10 6, 16 NiCrMo 12 6 11 NiMnCrMo 5 5, 17 MnCrMo 3 3 12 MnNiMo 5 5, 11 NiMoV 5 3 TStE 620 V - TStE 690 V	S500N P500NH P500NL - - - S620QL - S690QL
Pipe Materials	X70, X75 (API 5LX)	-
Heat Treated Fine Grained Structural Steels	N-A-XTRA 56, N-A-XTRA 63, N-A-XTRA 70 T1, T1A, T1B, HSB 77 V,	S550QL1, S620QL1, S690QL1 -