AS DA-778

Coated Electrode for High Strength Low Alloyed Steels

Classification

EN ISO 3580 : E CrMo 5 B 42
AWS A5.5 : E8018-B6

General Description

AS DA-778 is a basic coated electrode particularly used for the welding of steels containing 5 % Cr and 0.5 % Mo. The weld metal has a crack resistance to operating temperatures up to 550°C. Since it is a low hydrogen electrode, the weld metal has a high creep resistance. It has about 110 % metal recovery. It is recommended to use the electrode in DC (+).

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

C	Si	Mn	Cr	Mo
0.05	0.50	0.70	5	0.50

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 400 N/mm²
Tensile Strength : 580 N/mm²
Elongation (L=5d) : 22 %
Impact (ISO-V) : 80 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 - 100	2300	4.6 / 200	5
3.25	350	90 - 140	3640	4.9 / 135	5

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Applications and Materials to be Welded

Power plant constructions; flange pipes used in petrochemical plants; forged cast parts, vapor production plants, preheaters and heaters, boiler and pressure vessels and pipe connections are among some application areas where AS DA-778 is used. It can also be used in welding similarly alloyed cementation steels, heat treatable steels and cast steels.

Part should be preheated to 300°C before welding and operating temperature during welding should not exceed 350°C.

	DIN	EN	Werkstoff Nr.
Heat Resistant Steels	15 CrMo 3	–	1.7205
	25 CrMo 4	–	1.7218
	15 CrMo 5	–	1.7262
	22 CrMo 4 4	–	1.7350
	12 CrMo 19 5	X12 CrMo 5	1.7362
Cast Steels	GS-17 CrMo 5 5	G-17 CrMo 5 5	1.7357
	GS-25 CrMo 4	G-25 CrMo 4	1.7218
	GS-22 CrMo 5	G-22 CrMo 5	1.7252
	GS-22 CrMo 5 4	G-22 CrMo 5 4	1.7354
	GS-12 CrMo 19 5	G-X 12 CrMo 19 5	1.7363
Cementation Steels	15 Cr 3	–	1.7015
	–	16 MnCr 5	1.7131
	–	20 MnCr 5	1.7147