

SANBAZ

TOP FEATURES

- Excellent welding characteristics in all positions except vertical down position
- Very low spatter in both DC and AC, with a high deposition rate
- Low moisture reabsorption coated and Hd < 4 ml/100 g

CLASSIFICATION

AWS A5.1 E7018-1 H4R
EN ISO 2560-A E 42 5 B 4 2 H5

CURRENT TYPE

AC, DC+

WELDING POSITIONS

All positions, except vertical down

APPROVALS

ABS, LR, BV, DNV, RINA, TÜV, DB, CE

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S
0.070	1.2	0.4	≤0.020	≤0.010

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					-30°C	-45°C	-50°C
AWS A5.1	AW	≥400	≥490	≥22	≥27	≥27	-
EN ISO 2560-A	AW	≥460	530-680	≥20	-	-	≥47
Typical values	AW	≥430	510-590	≥22	≥27	≥27	≥90
Typical values	PWHT 620°C/1h	≥420	500-590	≥22	≥27	≥27	≥90

AW: As-welded; PWHT: Postweld Heat Treatment

- = not specified

OPERATING CURRENT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-90
3.2 x 450	120-140
4.0 x 450	160-190
5.0 x 450	180-230

AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CBOX	172	4.0	W100288468
3.2 x 450	CBOX	120	5.6	W100288470
4.0 x 450	CBOX	80	5.4	W100288472
5.0 x 450	CBOX	55	5.5	W100288473

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.