

ES 55.00

Type Lime-basic

SMAW

E7018-1

ESWECO
The Art of Welding

Description

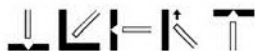
ES 55.00 is a reliable, high-quality, LMA electrode, particularly suitable for welding high strength low-alloy steels. The good, low-temperature impact strength of the weld metal should be noted. The weld metal is also very resistant to hot cracking. The electrode is also suitable for welding high strength ship's steel, grades A, D and E.

Recovery

125%

Current

AC, DC+ OCV 65 V



Classifications

SFA/AWS A5.1	E7018-1
EN 499	E 46 5 B 32 H5
ISO 2560	E 51 5B 120 26H

Typical all weld metal composition, %

C	Si	Mn
0.07	0.5	1.4

Typical mech. Properties all weld metal

Yield stress, MPa	480
Tensile strength, MPa	590
Elongation, %	28

Charpy V

Test temps, °C	Impact values, J
-20	115
-50	50

Approvals

ABS 3Y, H10

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	80-110	23
3.2	450	110-140	24
4.0	450	140-200	24
5.0	450	200-270	24