

ES 45.00

Type Lime-basic

SMAW

E7018

ESWECO
The Art of Welding

Description

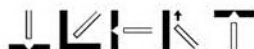
A reliable, general purpose, LMA electrode for mild and low-alloy steels. ES 45.00 deposits a tough, crack-resistant weld metal. High welding speed in the vertical-up position. ES 45.00 is insensitive to the composition of the base material within fairly wide limits. The electrode can be used for welding structures where difficult stress conditions cannot be avoided.

Recovery

125%

Current

DC + (-), AC



Classifications

SFA/AWS A5.1	E7018
EN 499	E 42 4 B 42 H5
ISO 2560	E51 5B 120 20H

Typical all weld metal composition, %

C	Si	Mn
0.06	0.5	1.2

Typical mech. Properties all weld metal

Yield stress, MPa	445
Tensile strength, MPa	540
Elongation, %	29

Charpy V

Test temps, °C	Impact values, J
-20	140
-40	70

Approvals

ABS	Grade 3Y,H5
LR	Grade 3Y

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	80-110	23
3.2	450	90-140	23
4.0	450	125-210	26
5.0	450	200-260	23