

Welding Rods AS B-248 H5

AS B-248 H5 is a basic coated electrode. It is used particularly to weld rigidly restrained mass structures where high welding stresses are unavoidable. Weld metal has a high resistance to cracking. The slag is easy to remove and it gives excellent quality, smooth weld beads. It is also suitable for welding in vertical upwards position at a high welding speed. It has 125% metal recovery

Classification and Typical Weld Metal Composition TS

EN ISO 2560-A : E 42 3 B 42 H5

AWS A5.1 : 7018

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C **Si** **Mn**

0,07 0,50 0,90

Mechanical Properties of the Weld Metal, Typical

Yield Strength : 460 (N/mm²)

Tensile Strength : 530 (N/mm²)

Elongation (L=5d) : 28 (%)

Impact ISO-V : 110 (Joule) (-30°C)

: 80 (Joule) (-40°C)

Note : Redrying temperature is 250-400°C / 2-3 hours

Approvals ve Certificates

Lloyd Approvals

ABS BV DNV GL LRS TL

Certificates

CE TSE

Applications and Materials to be Welded

AS B-248 H5 is suitable for steel constructions and machines operating under dynamic forces. Ship building, boiler and pressure vessel manufacturing and pipe connections are among its application areas. It is recommended for the welding of high carbon, high strength low alloyed steels having high (P) and (S) content; high strength ship's plate of A-, D- and E- quality and vessel plates of 17 Mn 4 and 19 Mn 5 type. AS B-248 H5 can join steel parts to steel casts and can be used in welding of thick parts. It is suitable for the root pass and welding in difficult positions. It gives excellent weld beads with high impact strength values at subzero temperatures. It is also very suitable for welding of GALVANIZED plates.

STANDARDS:

General Structural Steels : DIN: St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52 EN: S185, S235, S275, S355 DIN: St 37-4, St 44-4, St 52-4 EN: P235TR2 - P355T2 DIN: St 50-2, St 60-2 EN: E295, E335 DIN: C 55, Ck 55 EN: C55	Fine Grained Steels : DIN: StE 255 - StE 420 EN: S255N - S420N DIN: WStE 255 - WStE 420 EN: P255NH - P420NH DIN: TStE 255 - TStE 420 EN: S255NL - S420NL / P275NL1 - P355NL1 Elevated Temperature Steels : DIN: St 35-8, St 45-8 EN: P235G1TH - P255G1TH	Pipe Materials : DIN: StE 210-7 - StE 360-7 EN: L210 - L360NB DIN: StE 290-7 TM-StE 360-7 TM EN: L290MB - L360MB DIN: X42, X46, X52, X60 (API 5LX) Boiler & Pressure Vessel Steels : DIN: H1, H11, H111 EN: P235GH, P265GH, P285NH DIN: 17 Mn 4, 19 Mn 6 EN: P295GH, P355GH	Ship Plates : DIN: A, D, E DIN: AH32 - EH36 Cast Steels : DIN: GS-38, GS-45, GS-52, GS-60 EN: GE200, GE240, GE260, GE300 DIN: GS-62
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Art. no. 9820103252

P. Qty.: 1pkt (150 rods/pkt- 5.00 kg)