


<b>Technical data sheet</b> <small>011121MBA</small>	<b>Coated SMAW Electrode</b> <b>WA SPEEDARC HLE 620-E</b>	
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### CLASSIFICATION

ASME IIC SFA 5.1 / AWS A 5.1: E10018-G  
EN ISO 18275-A: E 62 5 1,5NiMo B 42 H5

### DESCRIPTION

- Basic coated electrode giving a 1.5% NiMo type steel deposit for service temperatures from -50°C to +400°C
- Welding of fine-grained high strength steels up to 650 MPa. Excellent low temperature toughness down to -50°C both as welded and stress relieved
- Preheat according to the type and thickness of the steel to be welded and to the degree of joint restraint
- Complements Welding Alloys cored wire ROBOFIL M 700 and ROBOFIL B 700

### APPLICATIONS

Field of application	Standard	Grade
Unalloyed construction steels	EN 10025	S355N, S500NL, S500NL1, P460NL1 P460NL2, S500QL
Pipe steels	API 5LX	X60; X65; X70

### TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Si	Mn	Cr	Ni	Mo
<0.1	0.5	1.4	0.3	1.5	0.3

### MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
720	620	22	-

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
780	650	25	+20°C : >130 -20°C : > 90 -50°C : > 50

### OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 450	4.0 x 450
Current [A]	70 - 90	115 - 135	130 - 175
= +	~ 70V		

Re-baking before use: 2 hours at 300/350°C

### WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE  
ASME IX: 1G, 2F, 2G, 3G, 4G

### PACKAGING

Electrode Ø x L [mm]	2.5x350	3.2x450	4.0x450
Weight/box [kg]	5	6.5	6.5
Electrodes/box	~ 238	~ 148	~ 100

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.