

Technical data sheet

01121MBA

Coated SMAW Electrode**WA SPEEDARC B Ni2-E****CLASSIFICATION**

ASME IIC SFA 5.5 / AWS A 5.5: E8018-C1-H4
 EN ISO 2560-A: E 46 6 2Ni B 32 H5

DESCRIPTION

- Basic coated all positional electrode giving a 2.5% Ni type steel deposit
- High resistance to initiation and propagation of cracks on account of its particularly low diffusible hydrogen content
- Excellent low temperature toughness down to -60°C, both as welded and stress relieved
- Pleasing arc characteristics, good bead appearance
- Complements Welding Alloys cored wire ROBOFIL R Ni2+

APPLICATIONS

Joining steels for low temperature application

Examples

Fine-grained steels	EN 10028-3	P275N, NH, NL1, NL2 to P460N, NH, NL1, NL2
	EN 10113	S275N to S460N, S275M to S460ML
Pressure vessel steels	EN 10028-2	P235GH to P355GH
		10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6
Pipe steels	EN 10208	L245NB to L415NB, L360QB to L450QB
	API 5LX	X42, X46, X 52, X60, X65
Shipbuilding steels	A, B, D, E, A32/36 to F40	
	ISO/TR 15608: Groups 1.1, 1.2, 1.3, 2.1 and 3.1	

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Ni	P	S
0.05	0.90	0.35	2.5	0.015	0.010

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
550	460	20	-60°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
600	500	25	-60°C: 100

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 450	4.8 x 450
Current [A]	60-90	100-140	140-180	190-250

Re-drying: 1 hour 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]	2.5 x 350	3.2 x 350	4.0 x 450
Weight/box [kg]	5	5	6.5

Other packaging and other sizes: 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.