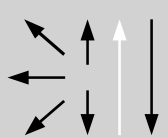


Classifications							
EN ISO 2560-A	EN ISO 2560-B	AWS A5.5	AWS A5.5M				
E 46 3 B 4 1	E5545-P2 A	E8045-P2	E5545-P2				
		E8018-G	E5518-G				
Characteristics and typical fields of application							
<p>Basic electrode for vertical-down welding of root passes in pipeline construction and structural work. Also suitable for vertical- up welding of root passes. The deposit is extremely crack resistant and features high toughness and a very low hydrogen content. Highly economical compared with conventional vertical-up welding.</p> <p>It can be used in sour gas applications (HIC-Test acc. NACE TM-02-84). Test values for SSC-test are available too.</p>							
Base materials							
<p>Root passes for following steels: S235J2G3 up to S355J2G3, L290NB - L415NB, L290MB - L555MB, P235GH - P310GH</p> <p>API Spec. 5 L: X 42, X 46, X 52, X 56, X 60, X 70, X 80</p>							
Typical analysis of all-weld metal (wt.-%)							
	C	Si	Mn				
wt-%	0.05	0.3	1.1				
Mechanical properties of all-weld metal							
Condition	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J			
	MPa	MPa	%	+20°C	±0°C	-20°C	-30°C
u	510 (≥ 460)	560 (550 - 680)	26 (≥ 20)	170	150	120	60 (≥ 47)
u untreated, as welded							
Operating data							
	Polarity: DC (+)	Redrying if necessary: 300 – 350°C / min. 2 h	Electrode identification: FOX BVD RP 8045-P2 E 46 3 B	ø (mm)	L mm	Amps A	
				2.5 3.2	350 350	80 – 110 100 – 160	
Interpass temperatures as required by the base material							
Approvals							
TÜV (03532.), SEPROZ, CE							