

Baso® G

TOP FEATURES

- Designed for works highly strained at static and dynamic loadings and service temperature down to -50°C
- Excellent welding characteristics in all positions except vertical down position.
- Very low spatter in both DC and AC, with a high deposition rate
- Low moisture absorption properties ensure extra low diffusible hydrogen level in the weld metal (< 4ml/100g).
- Good slag release and flat bead appearance

CLASSIFICATION

AWS A5.1 E7018-1 H4R
EN ISO 2560-A E 42 5 B 32 H5

CURRENT TYPE

AC/DC(+/-)

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	BV	DNV	TÜV	DB
+	+	+	+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	HDM
0.07	1.2	0.4	≤0.020	≤0.010	<4 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					+20°C	-47°C	-50°C
Required: AWS A5.1		min. 400	min. 490	min. 22		min. 27	
EN ISO		min. 420	500-640	min. 20			min. 47
Typical values	AW	≥430	575	≥24	200		≥90
	620°C x 1h	≥420	565	≥22	200		≥90

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.0x300	35-55
2.5x350	55-90
3.2x350	75-120
3.2x450	75-120
4.0x350	120-180
4.0x450	120-180
5.0x450	160-240

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5x350	SRP	60	1.4	511819-1
	CBOH	86	2.0	570823-1
	VPMD	86	2.0	521819
3.2x350	SRP	50	1.5	511918-1
	VPMD	52	1.9	521918
	CBOX	110	4.0	570762-1
3.2x450	SRP	50	2.4	511925-1
	VPMD	52	2.5	521919
	VPMD	116	5.5	570763-1
4.0x350	SRP	28	1.5	511901-1
	CBOX	81	4.2	570779-1
4.0x450	VPMD	37	2.5	521888
	CBOX	81	5.5	570816-1
5.0x450	SRP	21	2.1	511857-1
	CBOX	56	5.5	570786-1

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.