

SANBAZ

TOP FEATURES

- Excellent welding characteristics in all positions except vertical down position.
- Spatter very low in both DC and AC, with a high deposition rate.
- Low moisture reabsorption coated and Hd < 4 ml/100 g.

CLASSIFICATION

AWS A5.1 E7018-1 H4R
EN ISO 2560-A E 46 5 B 32 H5

CURRENT TYPE

AC, DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	BV	DNV	TÜV	DB	CE
+	+	+	+	+	+	+

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

C	Mn	Si	P	S
0.070	1.2	0.4	≤0.020	≤0.010

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					-30°C	-45°C	-50°C
AWS A5.1	AW	≥400	≥490	≥22	≥27	≥27	not specified
EN ISO 2560-A	AW	≥420	500-640	≥20	not specified	not specified	≥47
Typical values	AW	≥430	510-590	≥22	≥27	≥27	≥90
Typical values	PWHT 620°C x 1h	≥420	500-590	≥22	≥27	≥27	≥90

*AW: As-welded; PWHT: Postweld Heat Treatment

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-90
3.2 x 450	120-140
4.0 x 450	160-190
5.0 x 450	180-230

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	86	2.0	W000288476
	CBOX	172	4.0	W000288468
3.2 x 450	VPMD	52	2.5	W000288478
	CBOX	116	5.5	W000288470
4.0 x 450	VPMD	37	2.5	W000288480
	CBOX	81	5.5	W000288472
5.0 x 450	CBOX	56	5.5	W000288473

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.