

## C79-1XR

PRO FOR INDUSTRY



### Basic Electrode

AWS/ASME SFA 5.4 E7018  
EN ISO 2560-A E424B32H5

Basic coated electrode designed for high quality welds. Excellent strength and toughness properties. Suitable for welding fabrication of dynamically loaded steel constructions, bridge, shipbuilding, pipe-line, vessels, tanks, boiler and machines where high toughness is required. Also suitable for welding steels with low purity and high carbon content. Metal recovery about 120% Good weld ability.

#### Characteristics on Usage:

- Excellent usability with direction current applications.
- Ready the electrode at 300~350°C for 60 minutes prior to use

#### Typical chemical composition of all-weld-metal (%)

C	Si	Mn
0.07	0.57	0.97

#### Typical mechanical properties of all-weld-metal

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation %	Charpy V-notch J(-30 °C)
480	570	30	90

#### Sizes available Welding Current (AC or DC±)

Ø (mm)	2.50	3.2	4.00	5.00
AC, DC - (A)	60-100	90-130	130-180	200-250

#### Welding positions



**APPROVALS:** GL, ABS, LR, BUREAU VERITAS

