

Basic electrode

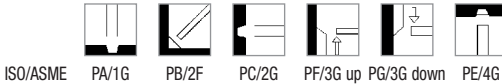
Classification

AWS A5.1-91 : E 7048 H8
 EN 499-94 : E 42 3 B 15 H10

General description

Basic coated low hydrogen electrode
 Special developed for vertical down welding on shipyards
 Complete fusion in open root passes
 Good tack weldability
 Good slag removal, smooth bead appearance

Welding positions



Current type

AC / DC electr. + / -

Approvals

ABS	BV	DNV	FORCE	GL	LR	RMRS
3Y	3Y	3YH10	+	3YH10	3,3YH10	3-3YH10

Chemical composition (w%), typical, all weld metal

C	Mn	Si	H _{DM}
0.09	1.1	0.7	6 ml/100 g

Mechanical properties, all weld metal

	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)		
					-20°C	-29°C	-30°C
Required: AWS A5.1-91		min. 399	min. 482	min. 22		min. 27	
EN 499-94		min. 420	500-640	min. 20			min. 47
Typical values	AW	580	630	26	130		

Packaging, available sizes and identification

	Diameter (mm)	3.2	4.0	5.0	5.6
Length (mm)		350	450	450	450
Unit: box	Pieces / unit (nominal)	150	100	70	56
	Net weight/unit (kg)	6.1	6.2	6.7	6.5

Identification Imprint: 7048/Baso 26V Tip colour: dark green

Baso[®] 26V: rev. EN 15

Materials to be welded

Steel	Code	Type
General structural steel	EN 10025	S185, S235, S275, S355
Ship plates	ASTM A131	Grade A, B, D, AH32 to EH36.
Cast steel	EN 10213-2	GP240R
Pipe material	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240, L290, L360, L415, L445
	API 5LX	X42, X46, X52, X60
	EN 10216-1/ EN 10217-1	P235T1, P235T2, P275T1 P275T2, P355N
Boiler & pressure vessel steel	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steel	EN 10113-2	S275, S275, S355, S420
	EN 10113-3	S275, S355, S420,

Calculation Data

Sizes Diam. x length (mm)	Current range (A)	Current type	Arc time - per electrode at (s)*	Energy - per electrode at E(kJ)	Dep.rate - current - H(kg/h)	Weight/ 1000 pcs. (kg)	Electrodes/ kg weldmetal B	kg Electrodes/ kg weldmetal 1/N
3.2 x 350	110 - 140	DC+	51	181	1.5	34.0	48	1.62
4.0 x 450	155 - 185	DC+	70	315	2.1	59.7	24	1.44
5.0 x 450	195 - 225	DC+	86	435	2.7	92.9	15	1.43
5.6 x 450	200 - 260							

* stub end 35 mm

Welding parameters, optimum fill passes

Welding position Diameter (mm)	PA/1G Current (A)	PG/3G down
3.2	130	130
4.0	145	175
5.0	220	220

Application Advice

Electrodes after removal from cardboard boxes redry 2-4h 350 ± 25°C