Baso® G

EMR SAHARA®

CLASSIFICATION

AWS A5.1	E7018-1 H4R	**A-Nr**	1
ISO 2560-A	E 42 5 B 32 H5	**F-Nr**	4
		9606 FM	1

GENERAL DESCRIPTION

Basic all position extremely low hydrogen electrode
115 - 120% recovery
AC/DC welding in all positions especially pipe
Excellent for site welding applications
Good pipe welding
Good impact values down to -50°C
Also available in vacuum sealed Sahara ReadyPack®(SRP)

WELDING POSITIONS (ISO/ASME)

PA/1G PB/2F PC/2G PF/3Gu PE/4G

CURRENT TYPE

AC / DC +/-

APPROVALS

ABS	DB	DNV	LR	GL	RINA	RMRS	TÜV
3H,3Y	3,3YH	3YH5	3,3YH5	3YH10	4YH5	3-3YH5	+

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

C	Mn	Si	HDM
0.05	1.3	0.4	2 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J) -20°C	-46°C	-50°C
Required: AWS A5.1		min. 400	min. 490	min. 22		min. 27	
ISO 2560-A		min. 420	500-640	min. 20			min. 47
Typical values	AW	490	575	28	200	130	100

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	2.5	3.2	3.2	4.0	4.0	5.0
	Length (mm)	350	350	450	350	450	450
Carton + PE foil	**Pieces / unit**	135	120	120	85	85	55
	Net weight/unit (kg)	2.8	4.4	5.8	4.7	5.9	6.0
SRP	**Pieces / unit**	69	50	50	28	28	23
	Net weight/unit (kg)	1.4	2.0	2.5	1.6	2.0	2.6

Identification Imprint: 7018-1/ BASO G+ Tip Color: blue

Baso® G: rev. C-EN27-01/02/16

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
General structural steels	
EN 10025	S185, S235, S275, S355
Ship plates	
ASTM A 131	Grade A, B, D, AH32 to EH40
Cast steels	
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	P235T1, P235T2, P275T1
EN 10217-1	P275T2, P355N
Boiler & pressure vessel steels	
EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steels	
EN 10025 part 3	S275, S355, S420
EN 10025 part 4	S275, S355, S420

CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type	Arc time - per electrode at max. current - (S)*	Energy - per electrode at max. current - E(kJ)	Dep. rate - per electrode at max. current - H(kg/h)	Weight/ 1000 pcs (kg)	Electrodes/ kg weldmetal B	kg electrodes/ kg weldmetal 1/N
2.0x300	35-55	DC+	50	61	0.5	11.7	149	1.75
2.5x350	55-90	DC+	59	107	0.8	20.3	78	1.59
3.2x350	75-120	DC+	70	234	1.2	36.5	42	1.54
3.2x450	75-120	DC+	79	265	1.4	45.4	33	1.47
4.0x350	120-180	DC+	75	358	1.7	50.9	28	1.45
4.0x450	120-180	DC+	96	473	1.7	69.3	22	1.52
5.0x450	160-240	DC+	114	671	2.2	106.2	14	1.54

*Stub end 35mm

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions PA/1G	PB/2F	PC/2G	PF/3Gup	PE/4G	PF/5Gup
2.0						45A
2.5	80A	80A	85A	90A	80A	80A
3.2	145A	120A	150A	120A	115A	120A
4.0	160A	145A	170A	150A	145A	145A
5.0	220A	210A	215A	170A		

REMARKS / APPLICATION ADVICE

Redry electrodes 2-4h 350 ±25°C after removal from cardboard boxes