

ESAB 36H (Spl)

ESAB 36H (Spl) is a basic coated low hydrogen iron powder electrode for low temperature applications. It is an all position electrode for welding medium tensile and fine grained carbon steels. The electrode exhibits very good mechanical properties after extended post weld heat treatment.

Specifications

Classifications	SFA/AWS A5.1 : E7018-1 IS 814 : EB5626H3JX
Approvals	IBR : E7018-1 LR : 4Y40 H15 PDIL : E7018-1

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+
Diffusible Hydrogen	< 5.0 ml/100g
Alloy Type	C-Mn
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	500 MPa	570 MPa	32 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	-40 °C	90 J
PWHT	-30 °C	150 J
PWHT	-46 °C	90 J
As Welded	-46 °C	75 J
As Welded	-30 °C	135 J
PWHT	-30 °C	160 J
PWHT	-46 °C	100 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Mn+Ni+Cr+ Mo+V
0.07	1.30	0.30	0.020	0.025	0.03	0.05	0.08	0.005	1.45

Deposition Data

Diameter	Current
2.5 x 350.0 mm	60-100 A
3.15 x 450.0 mm	80-140 A
4.0 x 450.0 mm	100-190 A
5.0 x 450.0 mm	180-260 A