LE B-255

CLASSIFICATION

AWS A5.1 E7018-1 H4
EN ISO 2560-A E 46 5 B 32 H5

GENERAL DESCRIPTION

LE B-255 is a basic coated electrode. Weld metal has high impact strength at low temperatures. As the weld metal is very resistant to hot cracking, it is used particularly to weld rigidly restrained mass structures where high welding stresses are unavoidable. The slag is easy to remove and it gives very high quality, smooth weld beads. It has 125 % metal recovery.

WELDING POSITIONS (ISO/ASME)

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

CURRENT TYPE

DC + ; AC min 65 V

APPROVALS

ABS	BV	DNV	GL	LRS	RINA	RMRS	CE
3H5, 3Y	3YHHH	3YH5	3YH5	3m 3Ym H5	3YH5	3YHHH	+

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

C	Mn	Si
0.07	1.20	0.50

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J) -20°C	Impact ISO-V(J) -50°C
Typical values	AW	480	580	30	180	120

Redrying Temperature : 300-400°C / 2-3 hours

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	2.5	3.2	4.0	5.0
	Length (mm)	350	350	450	450
Carton + PE foil	**Pieces / unit**	90	90	90	60
	Net weight/unit (kg)	2.2	3.4	6.6	6.4

Identification E7018-1 H4 / LE B-255 Tip Color: none

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EXAMPLES OF MATERIALS TO BE WELDED

LE B-255 is especially suitable for fine grained structural steels having high yield strength values. It is designed for steel constructions and machines operating under dynamic forces at low temperatures. Welding of ship's plate of A-, D- and Equality, boiler and pressure vessel manufacturing and pipe connections are among its application areas. LE B-255 can join steel parts to steel casts and can be used in the welding of thick parts. It is suitable for the root pass and welding in difficult positions. It gives excellent weld beads with high impact strength values at subzero temperatures.

	DIN	EN
General Structural Steels	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52 St 37-4, St 44-4, St 52-4 St 50-2, St 60-2, St 70-2 C 60, Ck 60	S185, S235, S275, S355 P235TR2 - P355T2 E295, E335, E360 C60
Fine Grained Steels	StE 255 - StE 420 WStE 255 - WStE 420 TStE 255 - TStE 420	S255N - S420N P255NH - P420NH S255NL - S420NL / P275NL1 - P355NL1
Pipe Materials	StE 210-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM - X42, X46, X52, X60 (API 5LX)	L210 - L360NB L290MB - L360MB L415NB -
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 6 HI, HII HIII	P295GH, P355GH P235GH, P265GH, P285NH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, D, E AH32 - EH36	- -
Cast Steels	GS-38, GS-45, GS-52, GS-60, GS-70 GS-62	GE200, GE240, GE260, GE300, S355J0C -

CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type	Electrode Weight [g/100 pcs]
2.5x350	80-110	DC+	2460
3.2x350	110-145	DC+	3890
4.0x450	130-190	DC+	7310
5.0x450	190-245	DC+	10640