

ESAB 36 H

A basic coated electrode for MMAW



Classification AWS A5.1: E 7018
IS: 814 EB 5426H₃JX



DESCRIPTION

ESAB 36H is a heavy basic coated hydrogen controlled iron powder electrode designed for welding in all positions. It gives tough, crack resistant weld on mild and low alloy steels. ESAB 36H deposits good X-ray quality welds and is ideal for welding rigidly resistant structures where stress cannot be avoided. ESAB 36H is designed to provide high recovery (>115%) with a thin easily detachable slag of excellent bead profile. Further, it has an extremely smooth and stable arc with good arc striking and re-striking characteristics even at OCV down to 60V.

APPROVALS

ABS Gr.3H15, BIS, BV Gr. 3YHH, CIB, DNV Gr.3YH15, LRS Gr.3, 3Y, H, MMD, NPC, PDIL, EIL, RDSO C2, D1, F, IRS GR.3YH.

WELDING CURRENT: DC±, AC 70V

TYPICAL APPLICATIONS

ESAB 36H is ideally suited for welding boiler quality and pressure vessel steels and heavy structures.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.08	Mn	1.20	YS	510 N/mm ²
Si	0.45	S	0.022	UTS	590 N/mm ²
P	0.022			EL (L=4d)	27%
				Impact (CVN) at -30°C	100J

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	80-110	130	520
3.15	450	120-150	90	360
4.00	450	150-190	60	240
5.00	450	180-260	40	160
6.30	450	250-310	25	100

PACKING: Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box.