

ESAB 36 H (Spl)

A basic coated electrode for MMAW



Classification AWS A5.1: E 7018-1
IS: 814 EB 5626H₃JX



DESCRIPTION

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 with AC or DC power supply. ESAB 36H (SPL) deposits weld metal of very low hydrogen content at a deposition efficiency of 115%. The weld metal is of high radiographic soundness, providing good mechanical properties and excellent impact strength at -50°C.

APPROVALS

MMD, NPC, PDIL, DNV, CIB.

WELDING CURRENT: DC+, AC 70V

TYPICAL APPLICATIONS

ESAB 36H (SPL) is ideal for welding of fine grained carbon manganese steels and medium tensile steels having UTS of 50-58 Kg/mm² and is recommended for welding of pressure vessels, boilers, hortonospheres, mounded bullets, heavy fabrication work and for pipelines subjected to low temperature.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.06	Mn	1.40	YS	450 N/mm ²
Si	0.30	S	0.02	UTS	570 N/mm ²
P	0.02			EL (L=5d)	28%
				Impact (CVN) at -50°C	70J

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	80-110	140	560
3.15	450	120-150	90	360
4.00	450	150-190	60	240
5.00	450	180-260	40	160

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