



P 48S

SMAW - (Stick) - MMA
Un-alloyed

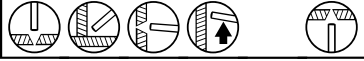
Date: 2007-10-19
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Description:

P 48S is a basic-coated, low hydrogen, general purpose electrode for use on DC+ only, for which the outstanding all-round operability has been optimised. The smooth, soft arc, easy slag control, all-positional welding, low spatter and excellent slag release provide maximum welder-appeal.

P 48S combines the good running characteristics required for general fabrication work with the exacting operability needs for pipe welding, where the fine spray transfer provides precise weld pool control and ensures an exceptionally regular and smooth root bead.

Welding positions:



Coating type:

Basic

Welding current:

DC + (-)

Hydrogen content / 100 g weld metal

≤ 4 ml

Metal recovery:

120%

Redrying temperature:

350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,40	1,10				
Typical	0,05	0,60	1,40	0,015	0,01		
Max	0,09	0,75	1,60	0,020	0,020	0,1	0,2

	Mo	Cu	V	Nb
Min				
Typical				
Max	0,1	0,2	0,05	0,05

Mechanical properties

	<u>Specified</u>	<u>Typical</u>	<u>PWHT Typical</u>
Yield strength, Re:	≥420 MPa	530 MPa	490 MPa
Tensile Strength, Rm:	510-640 MPa	600 MPa	580 MPa
Elongation, A5	≥ 22%	26%	29%
Impact energy, CV:	-40 °C • 47 J -46 °C • ≥27 J	-40 °C • 60 J -46 °C • 40 J	-20 °C • 130 J

Product data

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/kg electrodes	No. of electrodes/kg weld metal	Kg weld metal/hour arc time	Burn-off time/electrode (sec.)
1,6	300	71481620	30-60	23	0,65	170	0,5	46
2,0	300	71482020	40-80	23	0,64	115	0,7	43
2,5	350	71482520	80-110	23	0,71	60	1,0	54
3,2	450	71483220	110-155	24	0,72	28	1,6	76
3,2	350	71483520	110-165	24	0,72	36	1,6	57
4,0	450	71484020	140-205	25	0,74	19	2,1	82
5,0	450	71485020	200-285	25	0,75	13	2,9	91

Classification:

EN 499	E 42 4 B 42 H5
EN ISO 2560-A	E 42 4 B 42 H5
AWS A5.1	E 7018-1H4

Approvals:

BV	3 3Y HH
TÜV	
CE	
GL	3Y H5
ABS	3, 3Y
DB	Kennblatt Nr 10.042.01
DNV	3YH5
MRS	3Y 40 HHH
LR	3m, 3Ym, H5

Note

PWHT 600 C, 1 h

Core wire:

S ≤ 0.015%

P ≤ 0.015%

N ≤ 0.008%