Phoenix SH Ni 2 K 100

Stick electrode, low-alloyed, basic

Classifications

EN ISO 18275-A	AWS A5.5	AWS A5.5M
E 69 5 Mn2NiCrMo B 4 2 H5	E11018-G (E11018M mod.)	E7618-G (E7618M mod.)

Characteristics and typical fields of application

Basic covered NiCrMo alloyed electrode.

Low H_2-content ≤ 5 ml/100 g (HD) in the weld metal; very low moisture pickup during long term storage. For high strength fine grained structural steels, for cast steel qualities; weld metal insensitive to cold cracking.

Base materials

Quenched and tempered fine grained structural steels up to 720 MPa yield point.

High strength fine grained structural steels S620QL – S690QL, S620QL1, S690QU, HY 100, Suprafort 700,

N-AXTRA 56, 63, 70

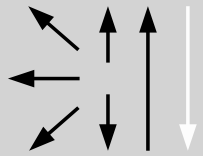
Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	Cr	Mo	Ni
wt-%	0.06	0.20	1.60	0.38	0.40	1.85

Mechanical properties of all-weld metal

Heat-treatment	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	–50 °C
aw	700	750	18	120	47
sr	690	740	19	120	47

Operating data



Polarity:	Redrying:	ø (mm)	L mm	Amps A
DC (+)	300 – 350 °C / 2 h (572 – 662 °F)	2.5	350	70 – 100
		3.2	350	90 – 140
		4.0	450	140 – 190
		5.0	450	180 – 250

Approvals

TÜV (00548), DB (10.132.35) ABS, BV, DNV, GL, WIWEB (für HY100 + Suprafort700), CE