Phoenix SH Ni 2 K 70

Stick electrode, low-alloyed, basic

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.5	AWS A5.5M
E 46 6 2Ni B 4 2 H5	E 5518-N5 AU H5	E8018-C1	E5518-C1

Characteristics and typical fields of application

Basic covered MnNi alloyed electrode for cryogenic steels.

Cold tough at subzero temperatures as low as –80 °C (–112 °F); NDT-tested. Useable in tank construction (LPG-tanks).

Base materials

Fine grained structural steels S275N – S420N;

Low temperature grades S275NL - S420NL;

Low temperature special grades P275NL2 – P355NL2, S420NL, 12 Ni14 G 1, X 12 Ni 5; 11 MnNi 5-3; 13 MnNi 6-3;

ASTM A633 Gr. E; A572 Gr. 65; A203 Gr. D, A333 and A334 Gr. 3, A350 Gr. LF3

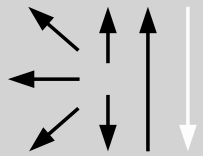
Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	Ni
wt-%	0.06	0.30	1.15	2.10

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	–80 °C
aw	470	560	26	140	47
sr	450	540	28	140	47

Operating data



Polarity:	Redrying:	ø (mm)	L mm	Amps A
DC (+)	300 – 350 °C / 2 h (572 – 662 °F)	3.2	350	100 – 150
		4.0	350	140 – 200
		5.0	450	170 – 250

Approvals

TÜV (01599), ABS, BV, GL, LR, DNV, CE