

# ESAB 36H

A basic coated low hydrogen electrode for SMAW

Classification AWS A5.1: E7018  
IS 814: EB5426H<sub>3</sub>JX

## 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 radiographic quality welds and is ideal for welding restraint structures where stresses can not be avoided.

**APPROVALS:** ABS, BV, DNV, IBR, IRS, LRS, MMD, NPC, PDIL & TOYO

**WELDING CURRENT:** DC+, AC 70V

## TYPICAL PROPERTIES

Weld Metal Composition (Wt.%)		All Weld Mechanical Properties	
C	0.07	YS (N/mm <sup>2</sup> )	470
Si	0.35	UTS (N/mm <sup>2</sup> )	540
Mn	1.25	Elongation (%)	28
		Impact (CVN) @ -30°C (Joules)	100

## CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	60-100	130	520
3.15	450	70-130	90	360
4.00	450	90-200	60	240
5.00	450	110-280	40	160

**PACKING:** Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box. This electrode can also be made available in moisture resistant vacuum packed cartons, which can be used without redrying.