

Baso[®] 26V

CLASSIFICATION

AWS A5.1	E7048 H8	A-Nr	1
ISO 2560-A	E 42 3 B 1 5 H10	F-Nr	4
		9606 FM	1

GENERAL DESCRIPTION

Basic low hydrogen electrode

Specially developed for vertical down welding on shipyards and light general construction works

Complete fusion in open root passes

Good tack weldability

Good slag removal, smooth bead appearance

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PG/3Gd



PE/4G

CURRENT TYPE

AC / DC +/-

APPROVALS

ABS	BV	DNV	LR	GL	RMRS
3Y	3Y	3YH10	3,3YH10	3YH10	3,3YH10

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	HDM
0.09	1.1	0.7	6 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
				-20°C	-29°C/-30°C
Required: AWS A5.1 ISO 2560-A	min. 400	min. 490	min. 22		min. 27
Typical values	min. 420 580	500-640 630	min. 20 26	130	min. 47

PACKAGING AND AVAILABLE SIZES

Carton + PE foil	Diameter (mm)	3.2	4.0	5.0
	Length (mm)	450	450	450
Pieces / unit	Net weight/unit (kg)	150	100	70
		6.1	6.2	6.7

Identification Imprint: 7048 / BASO 26V

Tip Color: dark green

Baso[®] 26: rev. C-EN25-01/02/16

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
General structural steels	
EN 10025	S185, S235, S275, S355
Ship plates	
ASTM A 131	Grade A, B, D, AH32 to EH36
Cast steels	
EN 10213-2	GP240R
Pipe material	
EN 10208-1	L210, L240, L290, L360
EN 10208-2	L240, L290, L360, L415, L445
API 5LX	X42, X46, X52, X60
EN 10216-1/	P235T1, P235T2, P275T1
EN 10217-1	P275T2, P355N
Boiler & pressure vessel steels	
EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steels	
EN 10025 part 3	S275, S355, S420
EN 10025 part 4	S275, S355, S420

CALCULATION DATA

Sizes		Current type	Arc time - per electrode at max. current - [S]*	Energy E(kJ)	Dep. rate H(kg/h)	Weight/ 1000 pcs [kg]	Electrodes/ kg weldmetal B	kg electrodes/ kg weldmetal 1/N
Diam. x length [mm]	Current range [A]							
3.2x450	110-140	DC+	51	181	1.5	34.0	48	1.62
4.0x450	155-185	DC+	70	315	2.1	59.7	24	1.44
5.0x450	195-225	DC+	86	435	2.7	92.9	15	1.43

*Stub end 35mm

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter [mm]	Welding positions		
	PA/1G	PG/3Gdown	PE/4G
3.2	130A	130A	125A
4.0	145A	175A	165A
5.0	220A	220A	200A

REMARKS / APPLICATION ADVICE

Redry electrodes 2-4h 350 ±25°C after removal from cardboard boxes