

# ESAB 36 H

## A basic coated electrode for MMAW



Classification AWS A5.1: E 7018  
IS: 814 EB 5426H<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 X-ray quality welds and is ideal for welding rigidly resistant structures where stress cannot be avoided. ESAB 36H is designed to provide high recovery (>115%) with a thin easily detachable slag of excellent bead profile. Further, it has an extremely smooth and stable arc with good arc striking and re-striking characteristics even at OCV down to 60V.

### APPROVALS

ABS Gr.3H15, BIS, BV Gr. 3YHH, CIB, DNV Gr.3YH15, LRS Gr.3, 3Y, H, MMD, NPC, PDIL, EIL, RDSO C2, D1, F, IRS GR.3YH.

**WELDING CURRENT:** DC±, AC 70V

### TYPICAL APPLICATIONS

ESAB 36H is ideally suited for welding boiler quality and pressure vessel steels and heavy structures.

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.08	Mn	1.20	YS	510 N/mm <sup>2</sup>
Si	0.45	S	0.022	UTS	590 N/mm <sup>2</sup>
P	0.022			EL (L=4d)	27%
				Impact (CVN) at -30°C	100J

### CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	80-110	130	520
3.15	450	120-150	90	360
4.00	450	150-190	60	240
5.00	450	180-260	40	160
6.30	450	250-310	25	100

**PACKING:** Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box.