



ESAB 36H



ESAB 36H is a 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. It deposits good radiographic quality welds and is ideal for welding restraint structures where stresses can not be avoided.

Classifications:	SFA/AWS A5.1:E7018, EN ISO 2560-A:E 42 3 B 32 H5
Approvals:	ABS 3YH5, BV 3YHH, DNV 3YH10, IBR E7018, IRS 3YHH, LR 3YmH15, PDIL E7018, M N Dastur

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	AC, DC+
Diffusible Hydrogen:	< 5.0 ml/100g
Alloy Type:	C-Mn
Coating Type:	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	470 MPa	550 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	-30 °C	100 J
As Welded	-40 °C	80 J

Typical Weld Metal Analysis %

C	Mn	Si
0.08	1.20	0.40

Current Range

Diameter	Current
2.5 x 350 mm	60-100 A
3.15 x 450 mm	80-130 A
4.0 x 450 mm	100-190 A
5.0 x 450 mm	180-260 A