Babcock H8

EN ISO 18275-A - E 69 2 Z B 3 2 H5 (Nearest)
AWS A5.5 E11018-G MOD 769 Issue 4
Superseded by Def Stan 02-769

The Babcock H8 is a basic coated low hydrogen electrode for welding very high strength, high toughness, low alloy steels.

Typical all weld metal chemical composition

C	Si	Mn	P	S	Cr	Mo	Ni	Cu	Nb	V
0.06	0.35	1.50	0.015	0.011	<0.05	0.31	1.90	<0.05	<0.05	<0.05

Typical all weld metal mechanical properties (as welded)

Yield Strength (N/mm^2)	Ultimate Tensile Strength (N/mm^2)	Elongation (%)	Reduction of Area (%)	Charpy V Notch (Joules)
688	783	20	63	>50 at (-) 50^0 C

Welding and packing data

Current conditions: DC+ or AC (Min OCV 70). DC preferred.

Stock Code	4103214	4103213	4103212
Size (mm)	3.2x450	4.0x450	5.0x450
Min. Amps.	110	140	200
Max. Amps	150	200	280
Approx. No. of Electrodes	(6x27) 162	(4x30) 120	(4x18) 72
Approx. Wt. per ctn. (kg)	7.5	8.0	7.5

The electrodes are vacuum packed in foil sleeves and packed in strongly constructed cardboard cartons.