

GENERAL DESCRIPTION

Elite 709 is a low hydrogen basic electrode for producing crack free welds in steels with a carbon content up to 0.40%. and welding unalloyed, micro-alloyed and low-alloy steels up to medium tensile strength with good operating and smooth-running characteristics in all positions except vertical down. Excellent mechanical properties, crack resistance and X-ray quality welds. This electrode is used where high standards are required, high ductility and smooth running.

- Exceptional arc stability
- Ultra-low diffusible hydrogen level : 4ml /100gms weld metal
- Unique self-lifting slag
- Excellent impact notch toughness
- Minimal spatter
- Smooth weld bead /High recovery
- All Positional except vertical down

WELDING POSITIONS



CLASSIFICATION

AS/NZS 4855B E4918-1AU H5
ISO 2560-A - E 42 4 B 32 H5
AWS A5.1 E7018-1 H4

CHEMICAL COMPOSITION

Wt% - wire	Si	C	Mn	P	S
	0.30	0.07	1.40	0.025	0.020

TYPICAL MECHANICAL PROPERTIES

Typical as welded	
Yield Strength	450 MPa
Tensile strength	550-620 MPa
Elongation A5(%)	28%
Impact Energy	80J @ -50°C

DEPOSITION DATA – AC / DC (+)

	2.5mm	3.2mm	4.0mm
Current (A)	60-80A	110-135A	140-180A
Voltage (V)	Determined by arc current and electrode arc length.		

Welding parameters are a guide only as they are dependent on the machine used, material thickness and operator experience.
No data is to be construed as a recommendation for any welding condition or technique by Euromarc.

CONFORMANCE AND APPROVAL

CE
LR
TUV

REBAKING

Rebaking is not necessary if the package is intact. Rebake :350C, 2 h

STORAGE

Store open packets in a heated cabinet.

WARNING

Electric shock can kill. Arc rays can injure eyes. Welding fumes are hazardous to your health and may damage lungs and other organs. Use adequate ventilation. Arc rays and sparks can injure eyes and burn skin. Wear correct hand, head, eye and body protection.

Read and understand the Safety Data Sheet for this product.

PACKAGING INFORMATION

Size	Weight	Length	Vacuumed Packed	Part Number / Order code
2.5mm	2kg	350mm	Yes	VE70925302
3.2mm	5kg	350mm	Yes	VE70932305
4.0mm	5kg	350mm	Yes	VE70940305

