

Type of Covering: High titania, potassium

Welding Position: F, H, HF, OH, V

Type of Current: AC, DCEP or DCEN

Features & Applications

CHE40 is the most popular mild steel welding rod. It is able to provide excellent welding performance and satisfactory weld metal can be obtained in all position welding. It is widely used in ordinary tensile strength mild steel structures especially suitable for intermittent welding to sheet steels and small work pieces as well as cosmetic welding with smooth and shiny appearance, e.g. top-hull of ships.

Chemical Composition of Deposited Metal (%)

	C	Mn	Si	S	P	Ni	Cr	Mo	V
Standard	≤0.20	≤1.20	≤1.00	≤0.035	≤0.040	≤0.30	≤0.20	≤0.30	≤0.08
Typical	0.070	0.41	0.26	0.021	0.023	0.018	0.027	0.002	0.001

Mechanical Properties of Deposited Metal (AW)

	Yield Strength ReH (MPa)	Tensile Strength Rm (MPa)	Elongation A4 (%)	Impact Value (J)	
				20	0
Standard	≥306	400-560	≥22	—	≥47
Typical	395	480	29	110	80

The standard of mechanical properties conforms to shipping institutions and the certificate of inspection would follow it unless the purchaser has special requirement.

X-ray radiographic inspection: Grade II

Sizes, Pieces & Recommended Current (AC or DC)

Size (mm)	2.5x300	2.5x350	3.2x350	4.0x400	4.0x450	5.0x400	5.0x450	
Pieces (5kg)	≈303	≈258	≈157	≈90	≈80	≈59	≈52	
Current (A)	F, H	60-90	60-90	80-130	150-190	150-190	180-250	180-250
	V, OH	50-80	50-80	80-110	130-170	130-170		

Approvals

Institute	CCS	LR	ABS	BV	GL	DNV	BKI	NK	CWB
Grade	2	2m	2	2	2	2	2	KMW2	E4313

Notice: Normally the rod do not need to re-dry in case it is affected with damp seriously it should be re-baked at 150 for 30-60minutes before use.