

### CLASSIFICATION

EN ISO 2560-A : E 42 2 B 11  
AWS A5.1 : E7048

### GENERAL DESCRIPTION

L-7048 is a basic coated electrode especially designed for welding in vertical downwards position, with a relatively large diameter electrode, at a very high travelling speed and high current. Thus, it can replace cellulosic coated electrodes in some circumstances. Weld metal has a high resistance to cracking.

### APPROVALS

GOST, SEPRO, TSE

### CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn
0.08	0.60	1.00

### MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

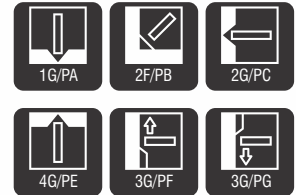
Yield Strength	: 460 N/mm <sup>2</sup>
Tensile Strength	: 560 N/mm <sup>2</sup>
Elongation (L=5d)	: 30 %
Impact (ISO-V)	: 80 J ( - 20°C)

Redrying Temperature : 250-400°C / 2-3 hrs

### WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : DC (+) ; AC min 70 V

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
3.25	350	110 - 150	3020	5.1 / 170	5
4.00	350	140 - 200	4480	4.3 / 95	5



### APPLICATIONS AND MATERIALS TO BE WELDED

L-7048 is especially suitable for steel constructions and machines operating under dynamic forces. Ship building, boiler and pressure vessel manufacturing and pipe connections are among its application areas. It is recommended for the welding of high carbon steels having high (P) and (S) content; high strength ship's plate of A-, D- and E- quality and also for low alloyed and structural steels of similar strength with the electrode.

	DIN	EN
<b>General Structural Steels</b>	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52 St 37-4, St 44-4, St 52-4 St 50-2, St 60-2	S185, S235, S275, S355 P235TR2 - P355T2 E295, E335
<b>Fine Grained Steels</b>	StE 255 - StE 420 WStE 255 - WStE 420 TStE 255 - TStE 420	S255N - S420N P255NH - P420NH S255NL - S420NL / P275NL1 - P355NL1
<b>Pipe Materials</b>	StE 210-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM X42, X46, X52, X60 (API 5LX)	L210 - L360NB L290MB - L360MB -
<b>Boiler and Pressure Vessel Steels</b>	17 Mn 4, 19 Mn 6 H1, H11, H111	P295GH, P355GH P235GH, P265GH, P285NH
<b>Elevated Temperature Steels</b>	St 35-8, St 45-8	P235G1TH - P255G1TH
<b>Ship Plates</b>	A, D, E AH32 - EH36	- -
<b>Cast Steels</b>	GS-38, GS-45, GS-52	GE200, GE240, GE260

**Liability** : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.

**Fumes** : Consult information on Welding Safety Sheet, available upon request.

#### Lion International U.K (M.E.) Limited

Monomark House, 27 Old Gloucester Street, London WC1N 3XX, United Kingdom.  
T: +44 20 74198760 F: +44 20 78319489 E: info@lionintweld.co.uk

#### Lion International Middle East FZC

P.O. Box 41654, W/H No. 1K-01/4, Hamriyah Free Zone, Sharjah, UAE.  
T: +971 6 5260461 F: +971 6 5260561 E: info.me@lionintweld.co.uk