

**Standards**

TS EN ISO 2560-A	: E 42 2 Mo C 21
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AWS A5.5	: E 7010 - G

**Chemical Composition of  
Weld Metal % (Typical)**

C	Si	Mn	Mo
0.10	0.15	0.4	0.3

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-20°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
min. 420	510 - 590	min. 47 J	min. 22

**Typical Base Material Grades**

- S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, P355T1, P235T2-P355T2, L210-L415NB, L290MB-L415MB, S235JRS1-S235J4S2, P235G1TH, P255G1TH, X42-X65 for root pass applications is using up to X70(L485MB)

**Features and Applications**

- It is used for root and filler passes in all welding positions of high strength steels, assembly pipelines, closed vessels and boilers, steel constructions
- Deep penetration, especially (obtained) at vertical-down position

**Welding Positions**

**Current Type**

D.C.(+)

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100234	2.50 x 350	3/32 x 14"	40 - 80	1700
3010100237	3.20 x 350	1/8 x 14"	65 - 125	2735
3010100240	4.00 x 350	5/32 x 14"	90 - 175	3990
3010100243	5.00 x 350	3/16 x 14"	140 - 220	6135

**Approvals:** TSE, CE, GOST-R, SEPRO