

Standards

TS EN ISO 2560-A	: E 42 4 B 32 H5
EN ISO 2560-A	: E 42 4 B 32 H5
AWS A5.1	: E 7016-1 H4

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

C	Si	Mn
0.07	0.6	1.0

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-46°C)	Elongation (L ₀ =5d ₀) (%)
min. 420	500-610	min. 47 J	min. 24

Typical Base Material Grades

- S235JR-E295, E335, S235J2G3-S355J2G3, C22, C35, P235T1-P355T1, P235T2,P355T2, L210-L360, L290MB-L320MB, P235G1TH, P255G1TH, P235GH-P295GH, S235JRS1 S235J4S, S315G1S-S355G3S, S255N-S355N, GE200-GE300
- API 5L: A, B, X42, X46, X52, X56, X60

Features and Applications

- Suitability for welding with AC power
- Suitability for use in out-of-position welding except for welding at vertical down position
- Excellent strength and toughness
- Suitability for use in the fields of steel constructions, boiler, container, machine manufacturing, and shipbuilding construction as well as for use in welding low-purity and high-carbon steels
- Suitability for the formation of welding buffer layers when building up high-carbon steels
- Weld deposits with very low hydrogen content
- Weld metal recovery of about 125%
- Requirement of re drying for minimum 2 hours at the temperatures between 300°C and 350°C

Welding Positions

Current Type

D.C. (+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100372	2.50 x 350	3/32 x 14"	80 -100	2320
3010100375	3.20 x 350	1/8 x 14"	100-140	3720
3010100378	4.00 x 350	5/32 x 14"	130 -190	5380
3010100381	4.00 x 450	5/32 x 18"	130 -190	6820

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