

Standards

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| TSENISO18275-A : E 69 5 Mn2NiCrMo B 42 H5 |
| EN ISO 18275-A : E 69 5 Mn2NiCrMo B 42 H5 |
| AWS A5.5 : E11018-MH4 |

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

| C | Si | Mn | Cr | Mo | Ni |
|------|-----|-----|------|------|-----|
| 0.05 | 0.2 | 1.6 | 0.35 | 0.45 | 2.2 |

Mechanical Properties

| Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Impact Strength (ISO-V/-50°C) | Elongation (L ₀ =5d ₀) (%) |
|--|--|----------------------------------|--|
| min. 690 | 760-960 | min. 47 J | min. 20 |

Typical Base Material Grades

- S620QL-S690QL, S620QL 1, HY100
- API 5L: X60, X65, X70, X80

Features and Applications

- Basic-type -coated and Ni-Cr-Mo -alloyed electrode character
- Applicability in welding of casting steels and high-strength fine-grained steels
- Weld metals with high resistance to cracking
- Low amounts of hydrogen (4 ml per 100 g of weld metal)
- Low amounts of moisture absorbed during long-term storage
- Requirement of re-drying for minimum 2 hours at the temperatures between 300°C and 350°C

Welding Positions

Current Type

D.C.(+)

Operating Data

| Product Code | Diameter x Length (mm) / (inch) | | Welding Current (A) | Weight g / 100 pcs |
|--------------|------------------------------------|------------|------------------------|-----------------------|
| 3010100609 | 2.50 x 350 | 3/32 x 14" | 80 - 110 | 2250 |
| 3010100612 | 3.20 x 350 | 1/8 x 14" | 100 - 140 | 3610 |
| 3010100618 | 4.00 x 450 | 5/32 x 18" | 130 - 190 | 6850 |
| 3010100624 | 5.00 x 450 | 3/16 x 18" | 190 - 240 | 10520 |

Approvals: CE, ABS, GOST-R, SEPRO