

**Standards**

TS EN ISO 2560-A	: E 46 6 1 Ni B 42 H5
EN ISO 2560-A	: E 46 6 1 Ni B 42 H5
AWS A5.5	: E 8018 -C3 H4

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

C	Si	Mn	Mo	Ni
0.07	0.3	1.0	0.15	1.0

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-60°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
min. 470	550-680	min. 47 J	min. 24

**Typical Base Material Grades**

- 11 MnNi53, 13MnNi63, TTSt35N, TTSt35V, TTSt41, TTSt45, S255N-S500N, S255NL-S500NL

**Features and Applications**

- Suitability for use in welding low-alloyed steels resistant to lower service temperatures
- Serviceability of weld metals at temperatures down to -60°C
- Weld metal recovery of approx. 120%
- 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
3010100660	2.50 x 350	3/32 x 14"	70 - 100	2190
3010100663	3.20 x 350	1/8 x 14"	110 - 140	3440
3010100669	4.00 x 350	5/32 x 14"	140 - 180	5130
3010100672	4.00 x 450	5/32 x 18"	140 - 190	6650
3010100678	5.00 x 450	3/16 x 18"	190 - 240	10500

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