

Standards

TS EN ISO 3580-A	: E MoV B 42 H5
EN ISO 3580-A	: E MoV B 42 H5
AWS A5.5	: E 9018-G H4

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

C	Si	Mn	Mo	Cr	V
0.06	0.3	1.2	1.0	0.45	0.5

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)	Heat Treatment
min. 530	min. 620	min. 47 J	min. 18	710 ±20 °C / 1h / 300°C (air)

Typical Base Material Grades

- 14MoV6-3, 24CrMoV5-5, 21CrMoV5-7, 21CrMoV5-11, G17CrMoV5-11

Features and Applications

- V-alloyed steels such as 14MoV6-3
- Electrode coating of basic character
- Serviceability at temperatures up to 580°C
- Pre-heating and interpass temperatures : 200°C-300°C
- Requirement of re-drying for min. 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
3010100789	2.50 x 350	3/12 x 14"	65 - 90	2180
3010100792	3.20 x 350	1/8 x 14"	90 - 130	3180
3010100795	4.00 x 350	5/32 x 14"	140 - 180	5160

Approvals: CE, GOST-R, SEPRO