

Standards

TS EN ISO 2560-A	: E 38 2 RB 12
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AWS A5.1	: ~ E 6013

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

C	Si	Mn
0.08	0.2	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) (%)
min. 380	470-570	min.47 J	min.24

Typical Base Material Grades

- S 235JR, S275JR, S235J2G3-S355J2G3, P235 GH, P265 GH, P255NH, P235T1-P355T1, P235T2-P355T2, P235G1TH, P255G1TH, L210-L360NB, S235JRS1-S235J2S1, S235JRS2-S235J2S2

Features and Applications

- Electrode of rutile-basic character
- Electrode coating with high thickness
- Suitability for welding of pressure pipes
- Smooth welding bead without undercutting

Welding Positions

Current Type

D.C.(-) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100102	2.50 x 350	3/32 x 14"	60 - 110	1930
3010100105	3.20 x 350	1/8 x 14"	90 - 140	3315
3010100108	4.00 x 350	5/32 x 14"	110 - 200	4730

Approvals: TSE, CE, GOST-R, SEPRO