

Standards

EN ISO 18276-A:T 69 6 Mn2NiCrMo M M 1 H5
EN ISO 18276-B:T 76 6 T15 1M N4C1M2 H5
AWS ASME 5.28:E110C-K4 H4
AWS ASME 5.28 M :E76C-K4 H4

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	P	S	Cr	Ni	Mo
0.05	0.4	1.6	<0.015	<0.015	0.5	2.2	0.5

Approvals: ABS, BV, DNV, TL

Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-40°C)	Impact Strength (ISO-V/-60°C)	Elongation (L ₀ =5d ₀) (%)
PWHT	min. 690	770-940	min. 75 J	min. 69 J	min. 17

PWHT: 250°C / 2 hours post-weld heat treatment

Typical Base Material Grades

- EN: L690M, S690QL, S690G1QL1
- ASTM: A517 / A537, A625, HY100 (16NiCrMo12-6)

Features and Applications

- Suitable for cranes, vessel, offshore, marine and apparatus construction, etc.
- Suitable for robotic welding with reliable re-ignition even when the contact tip is cold.
- It is suitable for robotic applications and multipass welding without in-between cleaning
- Shielding gas:Ar+CO₂

Welding Positions



Current Type

FCAW / D.C. (+)

Packaging Details

Diameter (mm) / (inch)		Weight (Kg)	Spool Type
1.20	0.047"	15	BS300