

Standards

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| TS EN ISO 2560-A | : E 46 6 B 42 H5 |
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| AWS A5.1 | : E 7018 - 1 H4 |
| AWS A5.1 | : E 7018-1 H4R |

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

| C | Si | Mn |
|------|-----|-----|
| 0.08 | 0.4 | 1.4 |

Mechanical Properties*

| Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Impact Strength (ISO-V/-60°C) | Elongation (Lo=5do) (%) |
|--|--|----------------------------------|----------------------------|
| min. 460 | 530-650 | min. 47 J | min. 24 |

* CTOD tested

Typical Base Material Grades

- S235JR-E295, E335, S235J2G3-S355J2G3, P235T1-P355T1, P235T2,P355T2, L210NB-L415NB, L290MB-L360MB, P235G1TH, P255G1TH, P235GH-P355GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S380N, P255NH-P355NH, S255NL-S460NL1, GE200-GE300
- API 5L: X42, X46, X52, X56, X60, X65

Features and Applications

- Suitability for use in welding of high-strength, fine-grained steels
- High ductility at low temperatures down to -60°C
- It is used for joining thick materials safely
- Weld metal recovery of approx. 120%
- Requirement of re-drying for minimum 2 hours at the temperatures between 300°C and 350°C
- CTOD tested.

Welding Positions

Current Type

D.C.(+)

Operating Data

| Product Code | Diameter x Length (mm) / (inch) | | Welding Current (A) | Weight g / 100 pcs |
|--------------|------------------------------------|------------|------------------------|-----------------------|
| 3010100423 | 2.50 x 350 | 3/32 x 14" | 80 - 100 | 2380 |
| 3010100426 | 3.20 x 350 | 1/8 x 14" | 100 - 140 | 3740 |
| 3010100432 | 4.00 x 450 | 5/32 x 18" | 130 -190 | 7000 |

Approvals: ABS , BV , GOST- R , SEPRO , CE