

Standards

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

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Ni
0.07	0.3	1.3	0.9

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-60°C)	Elongation (L ₀ =5d ₀) (%)
min. 480	550-670	min. 47 J	min. 20

Typical Base Material Grades

- E295, E335, S355J2G3, L210-L360NB, L210MB-L360MB, P310GH, P355GH, S380N-S460N, P380NH-P460NH, S380NL-S460NL, S255NL1-S420NL1, GE260-GE300
- API 5L: X42, X46, X52, X56, X60, X65

Features and Applications

- Content with Mn-Ni alloy
- High toughness and high resistance to cracking
- Suitability for use in welding high strength, fine-grained structural steels
- Suitability for use in welding of materials with service temperatures between -60°C and +350°C
- Very high values of impact resistance after aging
- Convenience of welding at all positions except for vertical down position
- Weld deposits with very low contents of hydrogen
- 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
3010100483	2.50 x 350	3/32 x 14"	80 - 110	2190
3010100486	3.20 x 350	1/8 x 14"	100 - 140	3570
3010100495	4.00 x 450	5/32 x 18"	130- 190	6660
3010100498	5.00 x 450	3/16 x 18"	190-240	10550

Approvals: TSE, CE, DNV-GL, SEPRO, GOST-R, SEPRO