

Standards

TS EN ISO 2560-A	: E 42 0 RR 53
EN ISO 2560-A	: E 42 0 RR 53
AWS A5.1	: E 7024

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn
0.07	0.4	0.7

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/0°C)	Elongation (L ₀ =5d ₀) (%)
min. 420	510 - 610	min. 47 J	min. 22

Typical Base Material Grades

- S 235JR, S275JR, S235J2G3-S355J2G3, P235GH, P265GH, P295GH, S235JRS1-S235J2S1, S235JRS2- S235J2S2,

Features and Applications

- Resistance to high current
- High welding efficiency (about 160%)
- Cost-saving in groove welding and in flat fillet welding

Welding Positions

Current Type

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

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100171	3.20 x 350	1/8 x 14"	120 - 180	4710
3010100177	4.00 x 450	5/32 x 18"	160 - 240	9830
3010100180	5.00 x 450	3/16 x 18"	200 - 320	14950

Approvals: TSE, ABS, RS, RINA, NK, BV, CE, DNV-GL, SEPRO, CWB