

Standards

TS EN ISO 2560-A	: E 35 A RR 12
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**Chemical Composition of
Weld Metal % (Typical)**

C	Si	Mn
0.05	max. 0.2	0.3

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 355	440-560	min. 47 J	min. 22

Features and Applications

- Soft and stable welding
- Spatter formation in low amounts
- Formation of easily-removable slags
- Used for Armco Iron and very low carbon and silicon content steels, zinc bath containers used in galvanized coating

Welding Positions

Current Type

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

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100150	3.20 x 350	1/8 x 14"	110 - 140	4090
3010100153	4.00 x 350	5/32 x 14"	140 - 180	6120
3010100156	5.00 x 350	3/16 x 14"	180 - 220	8160

Approvals: TSE, CE, SEPRO