

Standards

TS EN ISO 2560-A	: E 42 0 RR 33
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AWS A5.1	: E 7014

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

C	Si	Mn
0.07	0.4	0.6

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	520 - 600	min. 47 J	min. 22

Typical Base Material Grades

- S 235JR, S275JR, S235J2G3-S355J2G3, P235 GH, P265 GH, P255NH, S235JRS1-S235J2S1, S235JRS2-S235J2S2

Features and Applications

- Usability in welding at all positions
- Resistance to high current
- Soft and stable welding
- Spatter formation in low amounts
- Welding efficiency of about 110%

Welding Positions

Current Type

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

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010102195	3.20 x 350	1/8 x 14"	120 - 160	3558
3010102196	4.00 x 350	5/32 x 18"	150 - 220	5910

Approvals: TSE, CE, SEPRO, RCB