

Standards

TS EN ISO 3581-A	: E 18 8 Mn B 22
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AWS A5.4	: ~E 307-15

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

C	Si	Mn	Ni	Cr
0.1	0.7	6.0	8.6	18.5

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 390	580-750	min. 80 J	min. 35

Typical Base Material Grades

DIN: X 6 Cr 13	X 15 Cr 13	AISI: 405
X 6 Cr Al 13	X 22 CrNi 17	410
X 10 Cr 13 X	X 5 CrNi 13 4	420
8 Cr 17	X 8 CrTi 17	430
X 20 Cr 13	G-X 20 Cr 14	430 Ti
X 10 Cr Al 13	G-X 8 CrNi 13	431
X 10 Cr Al 7	G-X 30 CrSi 6	440
		502

Features and Applications

- Highly resistant steels, alloyed / unalloyed steels, armour steels, hard manganese steels, nonmagnetic steels, steels with 14% Mn hard-to-weld steels
- Joint welding of different metals with each other
- Resistance of weld metal to corrosion, wear, thermal shocks and working temperatures between -100 °C and +500 °C

Welding Positions

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100893	2.50 x 250	3/32 x 10"	60 - 80	1280
3010100898	3.20 x 350	1/8 x 14"	80 - 100	3170
3010102108	4.00 x 350	5/32 x 14"	110 - 140	4900

Approvals: TSE, CE, SEPRO