

Standards

TS EN ISO 3581-A	: E 18 9 MnMo B 22
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AWS A5.4	: E 307-15

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

C	Si	Mn	Ni	Mo	Cr
0.08	0.6	4.0	9.5	1.0	19.0

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	590-740	min. 78 J	min. 35

Typical Base Material Grades

DIN:	X 20 Cr 13	AISI:	403	440
	X 8 Cr 17		405	501
	X 22 CrNi 17		410	502
	X 5 CrNi 17		420	
	G-X 20 Cr 14		430	

Features and Applications

- Especially developed for the welding of armor steel
- Therefore this product using for hot work tool steels
- The welding of steels that are difficult to resource availability
- Stainless - Chromium, Chromium - Nickel steels and high strength steels welding

Welding Positions

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100928	3.20 x 350	3/32 X 10"	60 - 80	3130
3010100933	4.00 x 350	1/8 X 14"	80 - 110	4800

Approvals: TSE, CE, SEPRO