Standards

TS EN ISO 3581-A	: E 22 12 B 22
EN ISO 3581-A	: E 22 12 B 22
AWS A5.4	: E 309 -15

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Ni	Cr
0.085	0.9	1.8	12.5	22.5

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Elongation ($L_0=5d_0$) (%))
min. 360	550-650	min.47 J	min.25

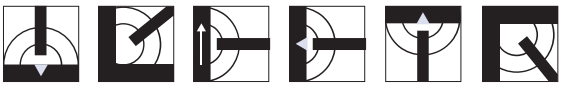
Typical Base Material Grades

- X15CrNiSi20 12, X10CrAl7, X10CrAl13, X10CrAl18, G-X40CrNiSi22, 9G-X40CrSi17, G-X30CrSi6, AISI 305, ASTM; A297HF

Features and Applications

- Basic-coated alloyed core wire electrode for welding analogous, heat resistant rolled, forged and cast steels as well as heat resistant ferritic CrSiAl steels
- For weld joints exposed to reducing, sulphurous gases, the final layer has to be deposited by means of this electrode
- In annealing plants, hardening plants, steam boiler construction, the crude oil industry and the ceramics industry
- Scaling resistant up to 1000°C

Welding Positions



Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101128	2.50 x 250	3/32 x 10”	60 - 80	1500
3010101133	3.20 x 350	1/8 x 14”	80 - 110	3250
3010101138	4.00 x 350	5/32 x 14”	110-140	4730

Approvals: TSE, CE, SEPRO