

Standards

TS EN ISO 3581-A	: E 19 12 3 Nb B 22
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AWS A5.4	: E 318-15

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

C	Si	Mn	Mo	Ni	Cr	Nb
0.04	0.45	1.45	2.75	11.5	20.0	+

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	590-730	min. 55 J	min. 30

Typical Base Material Grades

- EN: X6CrNiMoTi 17 12 2, X6CrNiMoNb 1 12 2, X5CrNiMo 17 13 2, G-XCrNiMo 18 10, X10CrNiMoNb 18 12, X5CrNiMo 17 13 3, G-X10CrNiMo 18 10, G-X10CrNiNb 18 10,
- AISI: 316Ti, 316Cb, 316L

Features and Applications

- Stabilized alloyed-core wire austenitic electrode with basic coating. Intended for use in all industries where analogous steels, including ferritic 13% chromium steels, are welded. Weld metal has high ductility, therefore preferably used for heavy sections. Very good out-of-position weldability. Resistant to intergranular corrosion up to 400°C. The weld metal does not require preheating or postweld heat treatment

Welding Positions

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101358	2.50 x 250	3/32 x 10"	60 - 80	1450
3010101363	3.20 x 350	1/8 x 14"	80 - 110	3500
3010101368	4.00 x 350	5/32 x 14"	110 - 150	5300

Approvals: TSE, CE, SEPRO