

Standards

TS EN ISO 3581-A	: E 18 8 Mn R 32
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AWS A5.4	: ~ E 307-16

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

C	Si	Mn	Ni	Cr
0.11	1.0	4.5	8.5	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	600-770	min. 47 J	min. 30

Typical Base Material Grades

DIN:	X 7 Cr 13	X 15 Cr 13	AISI:	405
	X 7 Cr Al 13	X 22 CrNi 17		410
	X 10 Cr 13	X 5 CrNi 134		420
	X 8 Cr 17	X 8 CrTi 17		430
	X 20 Cr 13	G-X 20 Cr 14		430 Ti
	X 10 Cr Al 7	G-X 8 CrNi 13		431
	X 10 Cr A 13	G-X 30 CrSi 6		440
				502

Features and Applications

- High resistant steels, alloyed / unalloyed steels, heat-resistant steels, Cr-stainless steels, steels including 14%Mn, hard-to-weld steels
- Joint welding and filler welding of difference metal with each other
- Electrode coating of rutile character
- Austenitic weld metal with resistance to thermal shocks
- Maintenance of toughness at temperatures down to -100°C
- Requirement of re-drying for min. 2 hours at the temperatures between 120°C and 200°C

Welding Positions

Current Type

D.C.(+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100908	2.50 x 250	3/32 x 10"	60 - 80	1350
3010100913	3.20 x 350	1/8 x 14"	80 - 110	3320
3010100918	4.00 x 350	5/32 x 14"	110 - 140	4810

Approvals: TSE, CE, SEPRO