

**Standards**

TS EN ISO 3581-A	: E 29 9 R 12
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AWS A5.4	: ~E 312-16

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

C	Si	Mn	Ni	Cr
0.12	1.0	0.8	10.5	30.0

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/+20°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
min. 490	700-830	min. 24 J	min. 20

**Typical Base Material Grades**

DIN:		AISI:	
X7Cr13	G-X7Cr13	403	
X7CrAl13	G-X20Cr14	405	
X10CrAl13	G-X10CrMo13	410	
X8Cr17	G-X8CrNi13	420	
X20Cr13		430	
X15Cr13		430Ti	
X22CrNi 17		431	
X15CrNi13 4		446	
X8CrTi17			

**Features and Applications**

- Alloyed-unalloyed high-resistant steels, Cr and Mn steels, joint welding of tool steels and different steels and repair welding of sprockets and wheelshaft
- Weld metal is resistant to corosions, cracks and rust
- 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
3010101208	2.50 x 250	3/32 x 10"	50 - 80	1260
3010101213	3.20 x 300	1/8 x 1 2"	80 - 110	2470
3010101218	3.20 x 350	1/8 x 14"	80 - 110	2890
3010101223	4.00 x 350	5/32 x 14"	110 - 160	4470

**Approvals:** TSE, CE, ABS, BV, SEPRO