

**Standards**

TS EN ISO 3581-A	: E Z 18 9 MnMo R 53
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AWS A5.4	: ~E307-26

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

C	Si	Mn	Ni	Mo	Cr
0.07	0.9	5.6	8.5	0.75	19.0

**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. 400	590-700	min. 47 J	min. 35

**Typical Base Material Grades**

DIN:	X 6 Cr 13	X 15 Cr 13	AISI:	405
	X 6 Cr Al 13	X 22 CrNi 17		410
	X 10 Cr 13	X 5 CrNi 13 4		420
	X 8 Cr 17	X 8 CrTi 17		430
	X 20 Cr 13	G-X 20 Cr 14		430Ti
	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**

- Welding of high resistant alloyed / unalloyed steels, heat-resistant steels / stainless steels, steels with 14% Mn, for welding problematic steels
- Joint and filler welding of different metals
- Rutile coated electrode, weld metal is austenitic, resistant to thermal shocks, keeps its toughness 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.(+)

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100943	3.20 x 350	1/8 x 14"	110 - 150	4900
3010100948	4.00 x 350	5/32 x 14"	140 - 180	7830

**Approvals:** TSE, CE, SEPRO