

**Standards**

TS EN ISO 3581-A	: E 19 9 R 53
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AWS A5.4	: E308-26

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

C	Si	Mn	Ni	Cr
0.07	0.8	1.0	9.0	18.0

**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. 410	570 - 710	min. 55 J	min. 30

**Typical Base Material Grades**

- X2CrNi 1911, X5CrNi 1911, X5CrNi 18 8, X12CrNi 17 7, X12CrNi 18 8, G-X10CrNi 18 8, G-X12CrNi 18 8,  
 AISI: 304 L, 304, 302, 301, 308

**Features and Applications**

- Applicability in joint- and surface-welding operations of 18/8 Cr-Ni steels, high-strength tempered steels, stainless steels and carbon steels
- Welding efficiency of approximately 150%
- Resistance to high current
- 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
3010101038	2.50 x 350	3/32 x 14"	80 - 120	2820
3010101043	3.20 x 350	1/8 x 14"	110 - 160	5700
3010101048	4.00 x 350	5/32 x 14"	150 - 190	7680

**Approvals:** TSE, CE, SEPRO