

**Standards**

TS EN ISO 2560-A	: E 38 2 RB 12
EN ISO 2560-A	: E 38 2 RB 12
AWS A5.1	: ~ E 6013

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

C	Si	Mn
0.08	0.2	0.5

**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. 380	470-570	min.47 J	min.24

**Typical Base Material Grades**

- S 235JR, S275JR, S235J2G3-S355J2G3, P235 GH, P265 GH, P255NH, P235T1-P355T1, P235T2-P355T2, P235G1TH, P255G1TH, L210-L360NB, S235JRS1-S235J2S1, S235JRS2-S235J2S2

**Features and Applications**

- Electrode of rutile-basic character
- Electrode coating with high thickness
- Suitability for welding of pressure pipes
- Smooth welding bead without undercutting

**Welding Positions**

**Current Type**

D.C.(-) / A.C.

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100102	2.50 x 350	3/32 x 14"	60 - 110	1930
3010100105	3.20 x 350	1/8 x 14"	90 - 140	3315
3010100108	4.00 x 350	5/32 x 14"	110 - 200	4730

**Approvals:** TSE, CE, SEPRO