

Standards

TS EN ISO 2560-A	: E 38 4 B 42 H5
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AWS A5.1	: E 7016-1 H4

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

C	Si	Mn
0.06	0.5	0.7

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-50°C)	Elongation (L ₀ =5d ₀) (%)
min. 400	490-600	min. 47 J	min. 24

Typical Base Material Grades

- S235JR-E295, S235J2G3-S355J2G3, C22, C35, P235T1-P355T1, P235T2,P355T2, L210 -L320, L290MB-L320MB, P235G1TH, P255G1TH, P235GH,P265GH, P295GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S355N, P255NH-P355NH, S255NL-S355NL, GE200 - GE240
- API 5L: A, B, X42, X46, X52, X56

Features and Applications

- Suitability for use in welding at all positions except for vertical down position
- Weld metal recovery of about 110%
- Weld deposits with very low hydrogen content
- High-quality and ductile, crack-resistant weld metals, mostly forming rigid weldments with beads of large cross-sections
- D.C. (-) is recommended for the root pass
- Requirement of re-drying for minimum 2 hours at the temperatures between 300°C and 350°C

Welding Positions

Current Type

D.C. (-) for root pass / D.C. (+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100336	2.50 x 350	3/32 x 14"	80 -110	2270
3010100339	3.20 x 350	1/8 x 14"	100 - 140	3610
3010100342	4.00 x 450	5/32 x 18"	130 -190	6760
3010100345	5.00 x 450	3/16 x 18"	190 - 240	10125

Approvals: TSE, CE, ABS SEPRO, DNV-GL