Standards

TS EN ISO 2560-A	: E 46 6 B 42 H5
EN ISO 2560-A	: E 46 6 B 42 H5
AWS A5.1	: E 7018 - 1 H4

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn
0.08	0.4	1.4

Mechanical Properties*

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-60°C)	Elongation ($L_o=5d_o$) (%)
min. 460	530-650	min. 47 J	min. 24

* CTOD tested

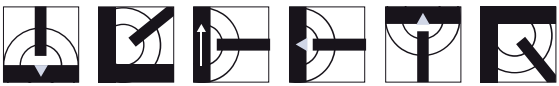
Typical Base Material Grades

- S235JR-E295, E335, S235J2G3-S355J2G3, P235T1-P355T1, P235T2,P355T2, L210NB-L415NB, L290MB-L360MB, P235G1TH, P255G1TH, P235GH-P355GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S380N, P255NH-P355NH, S255NL-S460NL1, GE200-GE300
- API 5L: X42, X46, X52, X56, X60, X65

Features and Applications

- Suitability for use in welding of high-strength, fine-grained steels
- High ductility at low temperatures down to -60°C
- It is used for joining thick materials safely
- Weld metal recovery of approx. 120%
- Requirement of re-drying for minimum 2 hours at the temperatures between 300°C and 350°C
- CTOD tested.

Welding Positions



Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100423	2.50 x 350	3/32 x 14”	80 - 100	2380
3010100426	3.20 x 350	1/8 x 14”	100 - 140	3740
3010100432	4.00 x 450	5/32 x 18”	130 -190	7000

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