

Standards

TS EN ISO 2560-A	: E 42 4 B 42 H5
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AWS A5.1	: E 7018 - H4

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

C	Si	Mn
0.08	0.6	1.2

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-40°C)	Elongation (L ₀ =5d ₀) (%)
min. 420	520-630	min. 47 J	min. 24

Typical Base Material Grades

- S235JR-E295, E335, S235J2G3-S355J2G3, C22, C35, P235T1-P355T1, P235T2,P355T2, L210-L360, L290MB-L360MB, P235G1TH, P255G1TH, P235GH-P355GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S355N, P255NH-P355NH, S255NL-S355NL, GE200-GE300
- API 5L: A, B, X42, X46, X52, X56, X60

Features and Applications

- Suitability for use in out-of-position welding except for welding at vertical down position
- Excellent strength and toughness
- Suitability for use in the fields of steel constructions, boiler, container, machine manufacturing and shipbuilding as well as for use in welding low purity and high-carbon steels
- The pressure vessels used in the production
- Suitability for the formation of welding buffer layers when building up high-carbon steels
- Weld deposits with very low hydrogen content
- Requirement of re-drying for minimum 2 hours at the temperatures between 300°C and 350°C

Welding Positions

Current Type

D.C. (+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100438	2.5 x 350	3/32 x 14"	60 - 90	2300
3010100441	3.2 x 350	1/8 x 14"	100 - 140	3700
3010100447	4.0 x 450	5/32 x 18"	150 - 210	6800
3010100450	5.0 x 450	3/16 x 18"	200 - 260	10200

Approvals: TSE, CE, SEPRO