

Standards

TS EN ISO 2560-A	: E 38 3 C 21
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AWS A5.1	: E 6010

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

C	Si	Mn
0.12	0.2	0.6

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-30°C)	Elongation (Lo=5d ₀) (%)
min.380	470-540	min.47 J	min.22

Typical Base Material Grades

- S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, P235T1-P355T1, P235T2-P355T2, L210-L360NB, L290MB-L360MB, S235JRS1-S235J2S2, P235G1TH, P255G1TH, X42-X56, for root pass X60-X80.

Features and Applications

- Suitability for use in welding large-diameter pipelines for crude oil, natural gas, and water as well as in root-pass welding or surfacing of ships, tanks, boilers, and steel constructions
- Usability in sour gas - involving applications (acc. HIC Test NACE TM-0284)
- Deep penetration obtained in welding at all positions
- Most suitability for welding at vertical down position

Welding Positions

Current Type

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

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100186	2.50 x 350	3/32 x 14"	40 - 80	1670
3010100189	3.20 x 350	1/8 x 14"	65 - 125	2720
3010100192	4.00 x 350	5/32 x 14"	90 - 175	4110
3010100195	5.00 x 350	3/16 x 14"	140-220	6210

Approvals: TSE, DNV-GL, TÜV, DB, CE, NACE, SEPRO, CWB