

Standards

TS EN ISO 2560-A	: E 42 0 RC 11
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AWS A5.1	: E 6013

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

C	Si	Mn
0.07	0.3	0.4

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/0°C)	Elongation (L ₀ =5d ₀) (%)
min. 420	510-610	min. 47 J	min.22

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 coating of medium-thickness
- Electrode coating of flexible type, providing electrode bendability
- Usability in welding of materials at hardly-reachable places
- Suitability for welding at vertical-down welding position

Welding Positions

Current Type

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

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100072	2.50 x 350	3/32 x 14"	60-110	1760
3010100075	3.20 x 350	1/8 x 14"	90-140	2920
3010100081	4.00 x 350	5/32 x 14"	130-200	4290
3010100084	4.00 x 450	5/32 x 18"	130-200	5510
3010100087	5.00 x 350	3/16 x 14"	170-240	6955
3010100090	5.00 x 450	3/16 x 18"	170-250	8800

Approvals: TSE, CE, TL, LR, TÜV, DB, SEPRO