

Standards

TS EN ISO 3580-A	: E CrMo1 R 12
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AWS A5.5	: E 8013-G

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

C	Si	Mn	Mo	Cr
0.06	0.4	0.6	0.5	1.1

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)	Heat Treatment
min. 460	min. 550	min. 47 J	min. 20	660-700°C / 1h / 300°C (air)

Typical Base Material Grades

- 13CrMo4-5, 15CrMo5, 16CrMoV4, S355NH

Features and Applications

- Welding of steam production plant equipments, steam pipes and similar kinds of heat-resistant joints, all of which are made of Cr-Mo alloy steels
- Electrode coating of rutile character
- Resistance of weld metal to operating temperatures of values up to 570°C

Welding Positions

Current Type

D.C. (-)
A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100738	2.50 x 350	3/32 x 14"	80 - 110	2150
3010100741	3.20 x 350	1/8 x 14"	100 - 140	3420
3010100744	4.00 x 350	5/32 x 14"	140 - 190	4760

Approvals: CE, SEPRO