

**Standards**

TS EN ISO 3580-A	: E MoV B 42 H5
EN ISO 3580-A	: E MoV B 42 H5
AWS A5.5	: E 9018-G H4

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

C	Si	Mn	Mo	Cr	V
0.06	0.3	1.2	1.0	0.45	0.5

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/+20°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)	Heat Treatment
min. 530	min. 620	min. 47 J	min. 18	710 ±20 °C / 1h / 300°C (air)

**Typical Base Material Grades**

- 14MoV6-3, 24CrMoV5-5, 21CrMoV5-7, 21CrMoV5-11, G17CrMoV5-11

**Features and Applications**

- V-alloyed steels such as 14MoV6-3
- Electrode coating of basic character
- Serviceability at temperatures up to 580°C
- Pre-heating and interpass temperatures: 200°C-300°C
- Requirement of re-drying for min. 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
3010100789	2.50 x 350	3/12 x 14"	65 - 90	2180
3010100792	3.20 x 350	1/8 x 14"	90 - 130	3180
3010100795	4.00 x 350	5/32 x 14"	140 - 180	5160

**Approvals:** CE, SEPRO