Standards

TS EN ISO 3580-A	: E Mo B 42 H5
EN ISO 3580-A	: E Mo B 42 H5
AWS A5.5	: E 7018-A1 H4

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Mo
0.07	0.4	0.9	0.5

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-50°C)	Elongation ($L_0=5d_0$) (%)	Heat Treatment
min. 460	530 - 670	min. 47 J	min. 22	620°C / 1h / 300°C (air)

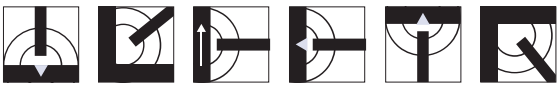
Typical Base Material Grades

- S355J2G3, E295, E335, P255G1TH, 16Mo3, L320-L415NB, L290MB-L415MB,S255N-S460N, P295GH P355GH, 15NiCuMoNb5S, 20MnMoNi4-5, 17MnMoV6-4, S255NH-S460NH, S255NL-S460NL, GE240-GE300, GS22Mo4

Features and Applications

- Basic-coated stick electrode
- Welding of heat-resisting, Mo-alloyed, thin-walled and unalloyed steels used for construction of boilers and pipes
- Weld metal is resistant to working temperatures from -50°C to +550°C
  Re-drying: 300-350°C min. 2h

Welding Positions



Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100720	2.50 x 350	3/32 x 14”	80 - 110	2200
3010100723	3.20 x 350	1/8 x 14”	100 - 140	3560
3010100729	4.00 x 450	5/32 x 18”	140 - 190	6590
3010100735	5.00 x 450	3/16 x 18”	190 - 240	10160

Approvals: TÜV, DB, CE, SEPRO