

Standards

TS EN ISO 3580-A : E Mo R 12
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**Chemical Composition of
Weld Metal % (Typical)**

C	Si	Mn	Mo
0.07	0.4	0.6	0.5

Mechanical Properties

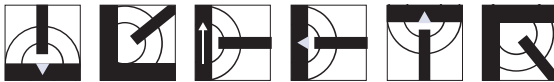
Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)	Heat Treatment
min. 355	min. 510	min. 47 J	min. 22	570-620°C / 1h / 300°C (air)

Typical Base Material Grades

- S355J2G3, E295, P255G1TH, L320- L415NB, 16Mo3, L290MB-L415MB, 16Mo3, S255N, P295GH, P355GH, P255-P355N, P255NH-P355NH

Features and Applications

- Welding of heat-resistant Mo-alloyed, fine-grained or unalloyed steels used for construction of boilers and pipes
- Weld metal is resistant to working temperatures up to +550°C

Welding Positions

Current Type

D.C. (+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100708	2.50 x 350	3/32 x 14"	80 - 100	2080
3010100711	3.20 x 350	1/8 x 14"	110-140	3310
3010100714	4.00 x 350	5/32 x 14"	140- 190	4900
3010100717	5.00 x 350	3/16 x 14"	190 - 240	7540

Approvals: CE, SEPRO