

Standards

TS EN ISO 2560-A	: E 42 0 RR 12
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AWS A5.1	: E 6013

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

C	Si	Mn
0.08	0.4	0.5

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

- Resistance to high current
- Soft and stable welding
- Spatter and fume formations in low amounts
- Formation of self-removable slags

Welding Positions

Current Type

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

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100045	2.50 x 350	3/32 x 14"	60 - 110	2120
3010100048	3.20 x 350	1/8 x 14"	90 - 150	3370
3010100054	4.00 x 350	5/32 x 14"	130- 200	5130
3010100057	4.00 x 450	5/32 x 18"	130- 200	6660
3010100060	5.00 x 350	3/16 x 14"	170 - 250	8090
3010100063	5.00 x 450	3/16 x 18"	170 - 250	10410

Approvals: TSE, CE, TL, DNV-GL, BV, ABS, LR, SEPRO