

**Standards**

TS EN ISO 2560-A	: E 50 3 B 42 H5
EN ISO 2560-A	: E 50 3 B 42 H5
AWS A5.5	: E 8018-G H4

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

C	Si	Mn
0.06	0.7	1.6

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-30°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
min. 500	550-720	min. 47 J	min. 19

**Typical Base Material Grades**

- S355J2G3, E295-E360, C35-C60, S315N-S500N, P315NH-P500NH, GE240-GE340  
Resistance of the rail steels up to 785 N/mm<sup>2</sup> are used.
- API 5L: X52, X56, X60, X65, X70

**Features and Applications**

- Suitability for use in welding carbon and low-alloyed high-strength steels with carbon contents up to 0.6%
- Suitability for use in rail-joint welding
- Ductile and crack-resistant weld metals
- Recovery of weld metals about 115%
- Weldability at all positions except for vertical down positions
- Weld deposits with very low contents of hydrogen
- Requirement of re-drying for minimum 2 hours at the temperatures between 350°C and 400°C

**Welding Positions**

**Current Type**

D.C.(+)

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100501	2.50 x 350	3/32 x 14"	80-110	2220
3010100504	3.20 x 350	1/8 x 14"	100 - 140	3590
3010100507	4.00 x 450	5/32 x 18"	130-190	6820
3010100510	5.00 x 450	3/16 x 18"	190 - 240	10500

**Approvals:** TSE, CE, SEPRO