

Standards

TS EN ISO 18275-A	: E 55 6 1 NiMo B 42 H5
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AWS A5.5	: E 8018 - G H4

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

C	Si	Mn	Ni	Mo
0.06	0.3	1.2	0.8	0.35

Mechanical Properties*

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-60°C)	Elongation (L ₀ =5d ₀) (%)
min. 550	630-750	min. 47 J	min. 19

* CTOD tested

Typical Base Material Grades

- E295-E360, 20MnMoNi5-5, 22NiMoCr4-7, S380N-S500N, S380NH-S500NH, S380NL-S500NL, S380NL1- S500NL1, 15NiCuMoNb5S, 17MnMoV6-4, C35-C60, GS60,
- API 5L: X52, X56, X60, X65, X70

Features and Applications

- Suitability for use in welding high-strength, fine-grained steels
- Consistent high ductility and crack-resistance at low working temperatures down to -60°C
- Resistance to aging
- Convenience of welding at all positions except for the vertical down position
- Possibility of applying same heat treatments temperatures at pre- and post- welding as well as at transition stages as those of base metal
- Very low contents of hydrogen
- Requirement of re-drying for minimum 2 hours at the temperatures between 300°C and 350°C

Welding Positions

Current Type

D.C.(+) / D.C. (-) for root pass

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100513	2.50 x 350	3/32 x 14"	80 - 110	2200
3010100516	3.20 x 350	1/8 x 14"	100 - 140	3640
3010100522	4.00 x 450	5/32 x 18"	130 - 190	6800
3010100528	5.00 x 450	3/16 x 18"	190-240	10500

Approvals: CE, ABS, SEPRO