

**Standards**

TS EN ISO 18275-A	: E 55 6 Z (1 NiMo) B 42 H5
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AWS A5.5	: E 9018-M H4

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

C	Si	Mn	Ni	Mo
0.05	0.3	1.1	1.4	0.3

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-60°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)	Heat Treatment
min. 550	620-780	min. 47 J	min. 24	AW

**Typical Base Material Grades**

- S380N-S500N, S355NH-S460NH, S380NL-500NL
- Fine grained, high strength steels and steel castings
- API 5L: X52, X56, X60, X65, X70

**Features and Applications**

- High resistance to cracking
- Low amounts of Hydrogen (4 ml / 100 g)
- Operability at temperatures between - 60°C and + 350°C
- Low content of moisture absorbed during long-term storage
- Requirement of re-drying for minimum 2 hours at the temperatures between 300°C and 350°C

**Welding Positions**

**Current Type**

D.C.(+)

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100546	2.50 x 350	3/32 x 14"	80 - 110	2250
3010100549	3.20 x 350	1/8 x 14"	100- 140	3640
3010100552	4.00 x 450	5/32 x 18"	130 - 190	6880
3010100555	5.00 x 450	3/16 x 18"	190 - 240	10130

**Approvals:** CE, SEPRO