Low Alloyed High Strength Electrode

TEMPO B 70 Mo

Standards

TS EN ISO 18275-A	: E 55 5 MnMo B 42 H5
EN ISO 18275-A	: E 55 5 MnMo B 42 H5
AWS A5.5	: ~ E 9018-D1 H4

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Mo
0.075	0.4	1.6	0.45

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-50°C)	Elongation ($L_0=5d_0$) (%)	Heat Treatment
min. 550	620-780	min. 47 J	min. 18	560-600°C / 1h / 300°C (air)

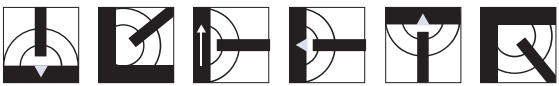
Typical Base Material Grades

- E295-E360, P355GH, 17MnMoV6-4, 15NiCuMoNb5S,S380N-S500N, P380NH-S500NH, GE300-GE340,G22Mo4
- API 5L: X52, X56, X60, X65, X70

Features and Applications

- Suitability for use in welding high-strength, fine-grained constructional steels and high-temperature steels
- Use in welding rail steels with strength values up to 785 N/mm^2
- Content including MnMo alloy
- Resistance to cracking as well as to aging, high toughness
- 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
3010100558	2.50 x 350	3/32 x 14”	80 - 110	2220
3010100561	3.20 x 350	1/8 x 14”	100 - 140	3670
3010100564	4.00 x 450	5/32 x 18”	130 - 190	6790
3010100567	5.00 x 450	3/16 x 18”	190 - 240	10130

Approvals: CE, SEPRO