

**Standards**

TS EN ISO 18275-A	: E 62 6 Z 1NiMo B 4 2 H5
EN ISO 18275-A	: E 62 6 Z 1NiMo B 4 2 H5
AWS A5.5	: E 10018 - G H4

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

C	Si	Mn	Cr	Mo	Ni
0.05	0.5	1.3	0.3	0.5	1.3

**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. 620	690-890	min. 47 J	min. 18	560-600°C / 1h / 300°C (air)

**Typical Base Material Grades**

- The yield strength of 620 N/mm<sup>2</sup> up to the quenched and tempered fine grain steels
- The tensile strength of the 780 N/mm<sup>2</sup> heat treating steels.

**Features and Applications**

- Content of Mn-Mo-Ni alloy
- High ductility and high resistance to cracking obtained in welding high-strength, quenched and tempered, fine-grained structural steels
- Suitability for use in welding of materials with service temperatures between -60°C and +400°C
- Very high values of impact resistance after aging
- Convenience of welding at all positions except for the vertical down position.
- Possibility of applying same heat treatment temperatures at pre- and post-welding as well as at transition stages as those of base metal
- Weld deposits with 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. (+)

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100582	2.50 x 350	3/32 x 14"	80 - 110	2280
3010100585	3.20 x 350	1/8 x 14"	100 - 140	3580
3010100588	4.00 x 450	5/32 x 18"	130 - 190	6680
3010100591	5.00 x 450	3/16 x 18"	190 - 240	10230

**Approvals:** CE, SEPRO