

Standards

TSENISO18275-A : E 69 5 Mn2NiCrMo B 42 H5
EN ISO 18275-A : E 69 5 Mn2NiCrMo B 42 H5
AWS A5.5 : E11018-MH4

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

C	Si	Mn	Cr	Mo	Ni
0.05	0.2	1.6	0.35	0.45	2.2

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-50°C)	Elongation (L ₀ =5d ₀) (%)
min. 690	760-960	min. 47 J	min. 20

Typical Base Material Grades

- S620QL-S690QL, S620QL 1, HY100
- API 5L: X60, X65, X70, X80

Features and Applications

- Basic-type -coated and Ni-Cr-Mo -alloyed electrode character
- Applicability in welding of casting steels and high-strength fine-grained steels
- Weld metals with high resistance to cracking
- Low amounts of hydrogen (4 ml per 100 g of weld metal)
- Low amounts 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
3010100609	2.50 x 350	3/32 x 14"	80 - 110	2250
3010100612	3.20 x 350	1/8 x 14"	100 - 140	3610
3010100618	4.00 x 450	5/32 x 18"	130 - 190	6850
3010100624	5.00 x 450	3/16 x 18"	190 - 240	10520

Approvals: CE, ABS, SEPRO