

Standards

TS EN ISO 18275-A : E 69 5 Z Mn2NiCrMo B 4 2 H5
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AWS A5.5 : E 12018 - G H4

Chemical Composition of Weld Metal % (Typical)

C	Si	Cr	Mo	Ni	Mn
0.06	0.4	0.9	0.5	2.5	1.6

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-50°C)	Elongation (Lo=5do) (%)	Heat Treatment
min. 740	830-950	min. 28 J	min. 17	560-600° C / 1h / 300° C (air)

Typical Base Material Grades

- HY 100, S690QL, S690QU, N-AXTRA 70
- API 5L: X60, X65, X70, X80

Features and Applications

- Suitability for use in welding fine-grained steels, cementation steels, tempered steels, cast steels etc.
- Suitability for use of applications requiring a minimum tensile strength value of 830 N/mm²
- Requirement of re-drying for minimum 2 hours at the temperatures between of 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
3010100627	3.2 x 350	1/8 x 14"	90 - 140	3670
3010100630	4.0 x 450	5/32 x 18"	130 - 190	6740
3010100633	5.0 x 450	3/16 x 18"	170 - 240	10530

Approvals: CE, SEPRO