

Standards

TS EN ISO 2560-A	: E 46 6 Z NiCrCu B 42 H5
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AWS A5.5	: E 8018 -W2 H4

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

C	Si	Cr	Ni	Cu	Mn
0.06	0.45	0.5	0.5	0.4	0.7

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-60°C)	Elongation (L ₀ =5d ₀) (%)
min. 460	550 - 680	min. 47 J	min. 20

Typical Base Material Grades

- S235JR, S235JRW, S325J2W, S355J2G1W, S355JRW, S355J2G 3 Cu, Patinax 37, 9CrNiCuP3-2-4 S255-S460, COR-TEN A,B,C

Features and Applications

- Content of Ni-Cu-Cr alloy
- Suitability for use in welding structural steels exposed to weathering, especially for COR-TEN B type steels.
- High mechanical properties with excellent crack resistance
- Convenience of welding at all positions except for vertical down position
- Weld deposits with very low contents of hydrogen
- 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
3010100651	2.50 x 350	3/32 x 14"	80 - 110	2200
3010100654	3.20 x 350	1/8 x 14"	130 - 150	3550
3010100657	4.00 x 450	5/32 x 18"	150 - 190	6700

Approvals: CE, SEPRO, TSE