TEMPO Ni Cu

Standards

TS EN ISO 2560-A	: E 42 3 Z NiCrCu B 42 H5
EN ISO 2560-A	: E 42 3 Z NiCrCu B 42 H5
AWS A5.5	: E7018-G/7018-W1(mod.)H4

Chemical Composition of Weld Metal % (Typical)

C	Si	Cr	Ni	Cu	Mn
0.06	0.5	0.3	0.4	0.4	1.0

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-30°C)	Elongation ($L_o=5d_o$) (%)
min. 420	510 - 630	min. 47 J	min. 22

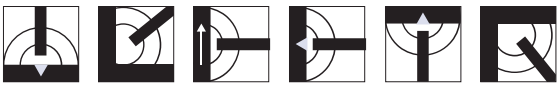
Typical Base Material Grades

- S235JR, S235JRW, S325J2W, S355J2G1W, S355JRW, S355J2G 3 Cu, COR-TEN A

Features and Applications

- Content of Ni-Cu-Cr alloy
- Suitability for use in welding structural steels exposed to weathering, such as COR-TEN.
- 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
3010100636	2.5 x 350	3/32 x 14”	80-110	2240
3010100639	3.2 x 350	1/8 x 14”	130-150	3520
3010100645	4.0 x 450	5/32 x 18”	150-190	6580
3010100648	5.0 x 450	3/16 x 18”	200-250	10100

Approvals: TSE, CE, SEPRO