

### Standards

TS EN ISO 3581 - A	: E 29 9 R 12
EN ISO 3581 - A	: E 29 9 R 12
AWS A5.4	: ~E 312-16

### Mechanical Properties

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))	Hardness (HB)
min. 450	790 - 860	20 - 25	250 - 300

### Features and Applications

- Include rebuilding gear teeth, repairing cracks in casing, buffering layers and repairs on earth moving and drilling equipment and rebuilding worn shafts
- Materials of low weldability such as unalloyed high carbon steels, low and high alloyed steels, tool steels, high speed steels, manganese hardening steels, rail steels and iron based cast materials
- It is also extremely usefull for repairs where the base metal is unknown grade steels
- High alloyed special manuel electrode for joining a broad range of difficult-to-weld metals including special, austenitic-manganese, air hardening materials for dissimilar joining
- Rutile type austenitic-ferritic electrode containing 29 9 Cr-Ni-Cobalt
- Weld metal hardness increases by work hardening and cold forming
- Depending on the ferrit content suitable for designed for joining difficult-to- weld steels, welding of dissimilar joints and rebuilding or buffering before hardsurfacing

### Welding Positions



### Current Type

D.C.(+) / AC

### Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Package Weight (Kg)	Weight g / 100 pcs
3030100032	2.50 x 250	3/32 x 10"	40-70	4	1350
3030100034	3.20 x 350	1/8 x 14"	70-100	5	3350
3030100036	4.00 x 350	5/32 x 14"	90-140	5	4500

Approvals: CE, SEPRO