

Standards :

TS EN ISO 3581 - A	:	E 18 8 Mn B 22
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AWS A5.4	:	~E 307-15

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

C	Si	Mn	Ni	Cr
0.1	0.7	6.0	8.6	18.5

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20 °C)	Elongation (L _o =5d _o)(%)
min. 390	580-750	min. 80 J	min. 35

Typical Base Material Grades :

DIN :	X 6 Cr 13	X 15 Cr 13	AISI :	405
	X 6 Cr Al 13	X 22 CrNi 17		410
	X 10 Cr 13	X 5 CrNi 13 4		420
	X 8 Cr 17	X 8 CrTi 17		430
	X 20 Cr 13	G-X 20 Cr 14		430 Ti
	X 10 Cr Al 7	G-X 8 CrNi 13		431
	X 10 Cr A 13	G-X 30 CrSi 6		440
				502

Features and Applications :

* Highly resistant steels, alloyed / unalloyed steels, armour steels, hard manganese steels, nonmagnetic steels, steels with 14% Mn hard-to-weld steels. * Joint welding of different metals with each other.
* Resistance of weld metal to corrosion, wear, thermal shocks and working temperatures between -100 °C and +500 °C. * Requirement of re-drying for at least 2 hours at temperatures between 150 °C and 200 °C.

Welding Positions :



Current Type :

D.C.(+)

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.50 x 250	3/32 x 10 ^{''}	60-80	1280
3.20 x 300	1/8 x 12 ^{''}	80-100	2510
3.20 x 350	1/8 x 14 ^{''}	80-100	2920
4.00 x 350	5/32 x 14 ^{''}	110-140	4320
5.00 x 350	3/16 x 14 ^{''}	150-170	6760

Approvals :

TSE, CE, GOST-R, SEPPO