

Standards :

TS EN ISO 3581 - A	: E 19 12 3 Nb B 22
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AWS A5.4	: E 318 - 15

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

C	Si	Mn	Mo	Ni	Cr	Nb
0.04	0.45	1.45	2.75	11.5	20.0	+

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20 °C)	Elongation (L ₀ =5d ₀)(%)
min. 390	590-730	min.55 J	min. 30

Typical Base Material Grades :

* X6CrNiMoTi 17 12 2, X6CrNiMoNb 17 12 2, X5CrNiMo 17 13 2,G-X5CrNiMo 18 10, X10CrNiMoNb 18 12, X5CrNiMo 17 13 3,G-X10CrNiMo 18 10, G-X10CrNiNb 18 10, 316, 316 Ti, 316Cb, 316 L

Features and Applications :

*Stabilized alloyed-core wire austenitic electrode with basic coating.Intended for use in all industries where analogous steels,including ferritic 13% chromium steels,are welded.Weld metal has high ductility,therefore preferably used for heavy sections.Very good out-of-position weldability.Resistant to intergranular corrosion up to 400°C.The weld metal does not require preheating or postweld heat treatment.

* Re-drying : 150 - 200°C / 2 h

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	1440
3.20 x 350	1/8 x 14"	80 - 110	3600
4.00 x 350	5/32 x 14"	110 - 150	4570

Approvals :

TSE, CE, GOST-R, SEPRO