

Standards :

TS EN ISO 3581 - A	:	E 18 8 Mn R 32
EN ISO 3581 - A	:	E 18 8 Mn R 32
AWS A5.4	:	~E 307-16

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

C	Si	Mn	Ni	Cr
0.11	1.0	4.5	8.5	19.0

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	600-770	min. 47 J	min. 30

Typical Base Material Grades :

DIN :	X 7 Cr 13	X 15 Cr 13	AISI :	405
	X 7 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 13	G-X 8 CrNi 13		431
	X 10 Cr Al 7	G-X 30 CrSi 6		440
				502

Features and Applications :

* High resistant steels, alloyed / unalloyed steels, heat-resistant steels, Cr-stainless steels, steels including 14%Mn, hard-to-weld steels. * Joint welding and filler welding of difference metal with each other. * Electrode coating of rutile character. * Austenitic weld metal with resistance to thermal shocks. * Maintenance of toughness at temperatures down to -100 °C. * Requirement of re-drying for at least 2 hours at the temperature 300-350 °C.

Welding Positions :



Current Type :

D.C.(+)
A.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	1350
3.20 x 350	1/8 x 14"	80 - 110	3320
4.00 x 350	5/32 x 14"	110 - 140	4810
5.00 x 350	3/16 x 14"	140 - 170	7520

Approvals :

TSE, CE, GOST-R, SEPRO