



INTER

Standards :

TS EN ISO 2560-A	:	E 38 0 RC 11
EN ISO 2560-A	:	E 38 0 RC 11
AWS A5.1	:	E 6013

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

C	Si	Mn
0.06	0.3	0.5

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/0°C)	Elongation (L ₀ =5d ₀)(%)
min. 390	470-590	min. 47 J	min. 22

Typical Base Material Grades :

* S 235JR, S275JR, S235J2G3-S355J2G3, P235 GH, P265 GH, P255NH, P235T1-P355T1, P235T2-P355T2, P235G1TH, P255G1TH, L210-L360NB, S235JRS1-S235J2S1, S235JRS2-S235J2S2

Features and Applications :

- * Electrode coating of flexible type, providing electrode bendability
- * Suitability for welding at vertical-down position
- * Deep penetration

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 350	3/32 x 14"	60 - 110	1850
3.20 x 350	1/8 x 14"	90 - 140	2940
4.00 x 350	5/32 x 14"	110 - 180	4250

Approvals :

TSE, CE, GOST-R, SEPRO