

Standards :

TS EN ISO 2560-A	: E 42 4 B 42 H5
EN ISO 2560-A	: E 42 4 B 42 H5
AWS A5.1	: E 7018-H4

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

C	Si	Mn
0.07	0.5	1.0

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-40°C)	Elongation (L ₀ =5d ₀)(%)
min. 420	510-600	min. 47 J	min. 24

Typical Base Material Grades :

* S235JR-E295, E335, S235J2G3-S355J2G3, C22, C35, P235T1-P355T1, P235T2,P355T2, L210-L360, L290MB-L360MB, P235G1TH, P255G1TH, P235GH-P295GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S355N, P255NH-P355NH, S255NL-S355NL,GE200-GE300

* API 5L : A, B, X42, X46, X52, X56, X60

Features and Applications :

* Suitability for use in out-of-position welding except for welding at vertical down position. * Excellent strength and toughness. * Suitability for use in the fields of steel constructions, boiler, container, machine manufacturing and shipbuilding as well as for use in welding low-purity and high-carbon steels

* Suitability for the formation of welding buffer layers when building up high-carbon steels. * Weld deposits with very low hydrogen content. * Weld metal recovery of about 120%

* Requirement of re-drying for minimum 2 hours at the temperatures between 300°C and 350°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 350	3/32 x 14"	80 - 100	2430
3.20 x 350	1/8 x 14"	100 - 140	3770
4.00 x 450	5/32 x 18"	130 - 190	7080
5.00 x 450	3/16 x 18"	190 - 240	10735

Approvals :

BV, DNV, TL, GL, DB, ABS, LR, RS, RINA, NK, TSE, TÜV, CWB, CE, GOST-R, SEPRO, HAKC (3.20 mm)