

### CLASSIFICATIONS

EN ISO 2560-A : E 42 2 Mo C 21

AWS A5.5 : E 7010 - G

### DESCRIPTION

- It is used for root and filler passes in all welding positions of high strength steels, assembly pipelines, closed vessels and boilers, steel constructions
- Deep penetration, especially (obtained) at vertical-down position

### CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.10 | Si: 0.15 | Mn: 0.4 | Mo: 0.3

### MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/20°C)	Elongation (L <sub>o</sub> =5d <sub>o</sub> ) (%)
min. 420	510 - 590	min. 47 J	min. 22

### BASE MATERIALS

- S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, P355T1, P235T2-P355T2, L210-L415NB, L290MB-L415MB, S235JR51-S235J4S2, P235G1TH, P255G1TH, X42-X65 for root pass applications is using up to X70(L485MB)

### WELDING POSITIONS



### CURRENT CONDITION

D.C.(+)

### OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
2010800090	2.50 x 350	3/32 x 14"	40 - 80	1700
2010800091	3.20 x 350	1/8 x 14"	65 - 125	2735
2010800092	4.00 x 350	5/32 x 14"	90 - 175	3990
2010800093	5.00 x 350	3/16 x 14"	140 - 220	6135